

Grizzly *Industrial, Inc.*®

MODEL G9743 7" x 12" GEAR HEAD METAL-CUTTING BANDSAW OWNER'S MANUAL



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**WARNING: NO PORTION OF THIS MANUAL MAY BE REPRODUCED IN ANY SHAPE
OR FORM WITHOUT THE WRITTEN APPROVAL OF GRIZZLY INDUSTRIAL, INC.**
#PCBL7711 PRINTED IN TAIWAN



WARNING!

This manual provides critical safety instructions on the proper setup, operation, maintenance and service of this machine/equipment.

Failure to read, understand and follow the instructions given in this manual may result in serious personal injury, including amputation, electrocution or death.

The owner of this machine/equipment is solely responsible for its safe use. This responsibility includes but is not limited to proper installation in a safe environment, personnel training and usage authorization, proper inspection and maintenance, manual availability and comprehension, application of safety devices, blade/cutter integrity, and the usage of personal protective equipment.

The manufacturer will not be held liable for injury or property damage from negligence, improper training, machine modifications or misuse.



WARNING!

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- **Lead from lead-based paints.**
- **Crystalline silica from bricks, cement and other masonry products.**
- **Arsenic and chromium from chemically-treated lumber.**

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: Work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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INTRODUCTION

Foreword

We are proud to offer the Model G9743 7" x 12" Gear Head Metal-Cutting Bandsaw. This machine is part of a growing Grizzly family of fine metalworking machinery. When used according to the guidelines set forth in this manual, you can expect years of trouble-free, enjoyable operation and proof of Grizzly's commitment to customer satisfaction.

We are pleased to provide this manual with the Model G9743. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our effort to produce the best documentation possible.

The specifications, drawings, and photographs illustrated in this manual represent the Model G9743 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at **www.grizzly.com**. Any updates to your machine will be reflected in these manuals as soon as they are complete. Visit our site often to check for the latest updates to this manual!

Contact Info

If you have any comments regarding this manual, please write to us at the address below:

Grizzly Industrial, Inc.
c/o Technical Documentation Manager
P.O. Box 2069
Bellingham, WA 98227-2069

We stand behind our machines. If you have any service questions or parts requests, please call or write us at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: <http://www.grizzly.com>





MACHINE DATA SHEET

Customer Service #: (570) 546-9663 · To Order Call: (800) 523-4777 · Fax #: (800) 438-5901

MODEL G9743 7" X 12" GEARED HEAD METAL-CUTTING BANDSAW

Product Dimensions:

Weight..... 375 lbs.
 Length/Width/Height..... 52 x 25 x 42 in.
 Foot Print (Length/Width)..... 40 x 16-3/8 in.

Shipping Dimensions:

Type..... Wood Slat Crate
 Content..... Machine
 Weight..... 440 lbs.
 Length/Width/Height..... 57 x 26 x 45 in.

Electrical:

Switch..... Automatic Shut Off
 Switch Voltage..... 110V
 Cord Length..... 7-1/2 ft.
 Cord Gauge..... 12 gauge
 Plug..... Yes

Motors:

Main

Type..... TEFC Capacitor Start Induction
 Horsepower..... 1-1/2 HP
 Voltage..... 110/220V
 Prewired..... 110V
 Phase..... Single
 Amps..... 23/11.5A
 Speed..... 1720 RPM
 Cycle..... 60 Hz
 Number Of Speeds..... 3
 Power Transfer Gear
 Bearings..... Shielded and Lubricated

Main Specifications:

Operation Info

Blade Speeds..... 148, 216, 282 FPM
 Std. Blade Len..... 104-1/2 in.

The information contained herein is deemed accurate as of 3/2/2006 and represents our most recent product specifications. Due to our ongoing improvement efforts, this information may not accurately describe items previously purchased.



Cutting Capacities

Angle Cuts.....	0 - 45 deg.
Vise Jaw Depth.....	9-3/4 in.
Vise Jaw Height.....	5 in.
Max. Capacity Rect. Height At 90D.....	7 in.
Max. Capacity Rect. Width At 90D.....	12 in.
Max. Capacity Rnd. At 90D.....	9 in.
Max. Capacity Rect. Height At 45D.....	5 in.
Max. Capacity Rect. Height At 30D.....	8 in.
Max. Capacity Rect. Width At 30D.....	8 in.
Max. Capacity Rnd. At 30D.....	8 in.
Max. Capacity Rect. Width At 45D.....	6 in.
Max. Capacity Rnd. At 45D.....	6 in.

Construction

Table Construction.....	Precision Ground Cast Iron
Wheel Construction Upper.....	Machined Cast Iron
Wheel Construction Lower.....	Machined Cast Iron
Body Construction.....	Cast Iron
Base Construction.....	Formed and Welded Steel with Coolant Sump
Wheel Cover Construction.....	Pre-formed Steel
Paint.....	Epoxy

Other

Wheel Size.....	12-1/2 in.
Blade Guides Upper.....	Adjustable Carbide
Blade Guides Lower.....	Adjustable Carbide
Coolant Cap.....	2.86 GAL

Table Info

Table Size Length.....	36 in.
Table Size Width.....	10-3/16 in.
Floor To Cutting Area Height.....	21-7/8 in.

Other Specifications:

ISO Factory	ISO 9001
Country Of Origin	Taiwan
Warranty	1 Year
Serial Number Location	Body Frame
Assembly Time	45 minutes
Sound Rating	80 dB

Features:

- Conveniently Located Control Panel
- Adjustable Hydraulic Downfeed
- Tru-Lock Vise for Rapid Change out of Workpiece
- Coolant Pump with Coolant Nozzle
- Gear Step Blade Speeds
- Heavy-duty all Steel, One Piece Base
- Worm Gear Box has Hardened and Ground Gears
- 45 deg. Miter Cutting Ability
- Blade Wheels have Heavy-Duty Ball Bearings
- Magnetic Safety Switch
- Includes 1" Blade



Identification

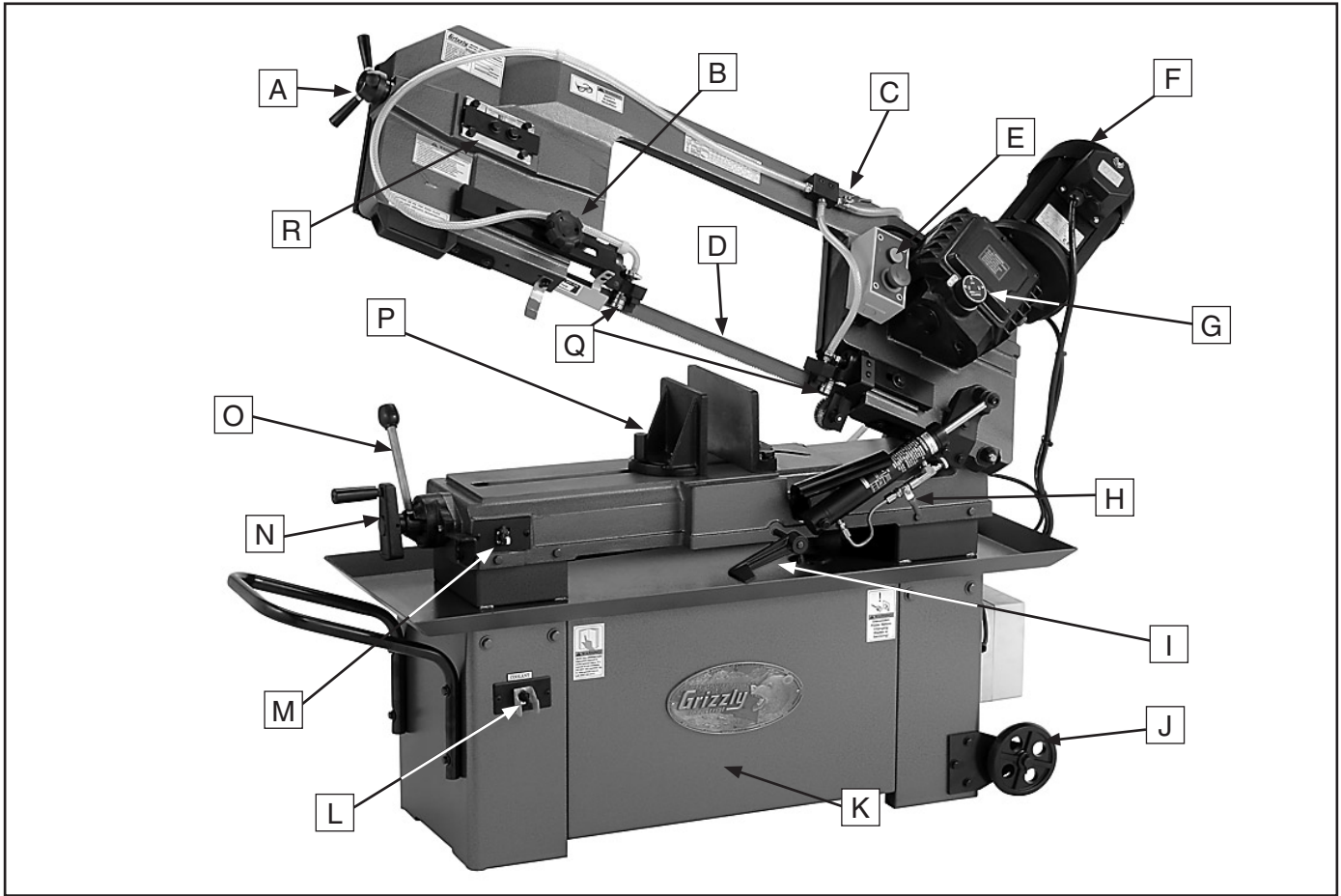


Figure 1. Main view of machine features.

- | | |
|-------------------------------|----------------------------|
| A. Blade Tension Handle | J. Wheels |
| B. Guide Post Adjustment Knob | K. Bandsaw Stand |
| C. Coolant Control Valve | L. Pump Toggle Switch |
| D. Blade | M. Limit Switch |
| E. ON/OFF Switch | N. Handwheel |
| F. 1½ HP Motor | O. Positive Locking Handle |
| G. Speed Control Knob | P. Vise |
| H. Feed Rate ON/OFF Valve | Q. Blade Guides |
| I. Workstop | R. Blade Tracking Controls |



SECTION 1: SAFETY


WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Machine

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.

 **DANGER** Indicates an imminently hazardous situation which, if not avoided, WILL result in death or serious injury.

 **WARNING** Indicates a potentially hazardous situation which, if not avoided, COULD result in death or serious injury.

 **CAUTION** Indicates a potentially hazardous situation which, if not avoided, MAY result in minor or moderate injury. It may also be used to alert against unsafe practices.

NOTICE This symbol is used to alert the user to useful information about proper operation of the machine.

WARNING

Safety Instructions for Machinery

- 1. READ THROUGH THE ENTIRE MANUAL BEFORE STARTING MACHINERY.** Machinery presents serious injury hazards to untrained users.
- 2. ALWAYS USE ANSI APPROVED SAFETY GLASSES WHEN OPERATING MACHINERY.** Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- 3. ALWAYS WEAR AN NIOSH APPROVED RESPIRATOR WHEN OPERATING MACHINERY THAT PRODUCES DUST.**
- 4. ALWAYS USE HEARING PROTECTION WHEN OPERATING MACHINERY.** Machinery noise can cause permanent hearing damage.
- 5. WEAR PROPER APPAREL. DO NOT** wear loose clothing, gloves, neckties, rings, or jewelry which may get caught in moving parts. Wear protective hair covering to contain long hair and wear non-slip footwear.
- 6. NEVER OPERATE MACHINERY WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Be mentally alert at all times when running machinery.



WARNING

Safety Instructions for Machinery

7. **ONLY ALLOW TRAINED AND PROPERLY SUPERVISED PERSONNEL TO OPERATE MACHINERY.** Make sure operation instructions are safe and clearly understood.
8. **KEEP CHILDREN AND VISITORS AWAY.** Keep all children and visitors a safe distance from the work area.
9. **MAKE WORKSHOP CHILD PROOF.** Use padlocks, master switches, and remove start switch keys.
10. **NEVER LEAVE WHEN MACHINE IS RUNNING.** Turn power **OFF** and allow all moving parts to come to a complete stop before leaving machine unattended.
11. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** DO NOT use machinery in damp, wet locations, or where any flammable or noxious fumes may exist.
12. **KEEP WORK AREA CLEAN AND WELL LIT.** Clutter and dark shadows may cause accidents.
13. **USE A GROUNDED EXTENSION CORD RATED FOR THE MACHINE AMPERAGE.** Undersized cords overheat and lose power. Replace extension cords if they become damaged. DO NOT use extension cords for 220V machinery.
14. **ALWAYS DISCONNECT FROM POWER SOURCE BEFORE SERVICING MACHINERY.** Make sure switch is in OFF position before reconnecting.
15. **MAINTAIN MACHINERY WITH CARE.** Keep blades sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
16. **MAKE SURE GUARDS ARE IN PLACE AND WORK CORRECTLY BEFORE USING MACHINERY.**
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Make a habit of checking for keys and adjusting wrenches before turning machinery **ON**.
18. **CHECK FOR DAMAGED PARTS BEFORE USING MACHINERY.** Check for binding and alignment of parts, broken parts, part mounting, loose bolts, and any other conditions that may affect machine operation. Repair or replace damaged parts.
19. **USE RECOMMENDED ACCESSORIES.** Refer to the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.
20. **DO NOT FORCE MACHINERY.** Work at the speed for which the machine or accessory was designed.
21. **SECURE WORKPIECE.** Use clamps or a vise to hold the workpiece when practical. A secured workpiece protects your hands and frees both hands to operate the machine.
22. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
23. **MANY MACHINES WILL EJECT THE WORKPIECE TOWARD THE OPERATOR.** Know and avoid conditions that cause the workpiece to "kickback."
24. **ALWAYS LOCK MOBILE BASES (IF USED) BEFORE OPERATING MACHINERY.**
25. **BE AWARE THAT CERTAIN MATERIALS MAY CAUSE AN ALLERGIC REACTION** in people and animals, especially when exposed to fine dust. Make sure you know what type of dust you will be exposed to and always wear an approved respirator.



WARNING

Safety Instructions for Metal Cutting Bandsaws

- 1. BLADE CONDITION.** Do not operate with dull, cracked or badly worn blade. Inspect blades for cracks and missing teeth before each use.
- 2. HAND PLACEMENT.** Never position fingers or thumbs in line with the cut. Hands could be crushed in vise or from falling machine components.
- 3. ENTANGLEMENT HAZARDS.** Do not operate this bandsaw without blade guard in place. Loose clothing, jewelry, long hair and work gloves can be drawn into working parts.
- 4. BLADE REPLACEMENT.** When replacing blades, make sure teeth face toward the workpiece. Wear gloves to protect hands and safety glasses to protect eyes.
- 5. WORKPIECE HANDLING.** Always support the workpiece with table, vise, or some type of support fixture. Flag long pieces to avoid a tripping hazard. Never hold the workpiece with your hands during a cut.
- 6. LOSS OF STABILITY.** Unsupported workpieces may jeopardize machine stability and cause the machine to tip and fall which could cause serious injury.
- 7. POWER INTERRUPTION.** Unplug machine after power interruption. Machines without magnetic switches can start up after power is restored.
- 8. FIRE HAZARD.** Use EXTREME CAUTION if cutting magnesium. Using the wrong cutting fluid will lead to a chip fire and possible explosion.
- 9. CUTTING FLUID SAFETY.** Always follow manufacturer's cutting-fluid safety instructions. Pay particular attention to contact, contamination, inhalation, storage and disposal warnings. Spilled cutting fluid invites slipping hazards.
- 10. ATTENTION TO WORK AREA.** Never leave a machine running and unattended. Pay attention to the actions of others in the area to avoid unintended accidents.
- 11. MAINTENANCE/SERVICE.** All inspections, adjustments, and maintenance are to be done with the power **OFF** and the plug pulled from the outlet. Wait for all moving parts to come to a complete stop.
- 12. HEARING PROTECTION & HAZARDS.** Noise generated by blade and workpiece vibration, material handling, and power transmission can cause permanent hearing loss over time and interfere with communication and audible signals.
- 13. HOT SURFACES.** Contact with hot surfaces from machine components, ejections of hot chips, swarf and workpiece can cause burns.

WARNING

No list of safety guidelines can be complete. Every shop environment is different. Like all machines there is danger associated with the Model G9743. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.



SECTION 2: CIRCUIT REQUIREMENTS

110/220V Operation

⚠️ WARNING

Serious personal injury could occur if you connect the machine to the power source before you have completed the set up process. **DO NOT** connect the machine to the power source until instructed to do so.

Amperage Draw

The Model G9743 features 110/220V motor that is prewired for 110V and draws the following amps under maximum load:

Motor Draw at 110V 23 Amps
Motor Draw at 220V 11.5 Amps

Circuit Requirements

We recommend connecting this machine to a dedicated circuit with a verified ground, using the circuit breaker size given below. Never replace a circuit breaker with one of higher amperage without consulting a qualified electrician to ensure compliance with wiring codes. **If you are unsure about the wiring codes in your area or you plan to connect your machine to a shared circuit, you may create a fire hazard—consult a qualified electrician to reduce this risk.**

110V Circuit Breaker 25 Amps
220V Circuit Breaker 15 Amps

Wiring for 220V

The Model G9743 can be rewired to operate on a 220V power source. The motor must be rewired according to the wiring diagram on the motor label. The wiring configuration can also be found on the inside of the motor wire cover, as well as on **Page 39**.

Plug Type

The Model G9743 comes prewired with a NEMA 5-15 plug. If you wish to rewire the motor to 220V you will need the following 220V plug (see **Figure 2** for an example):

220V Plug & Receptacle 6-15

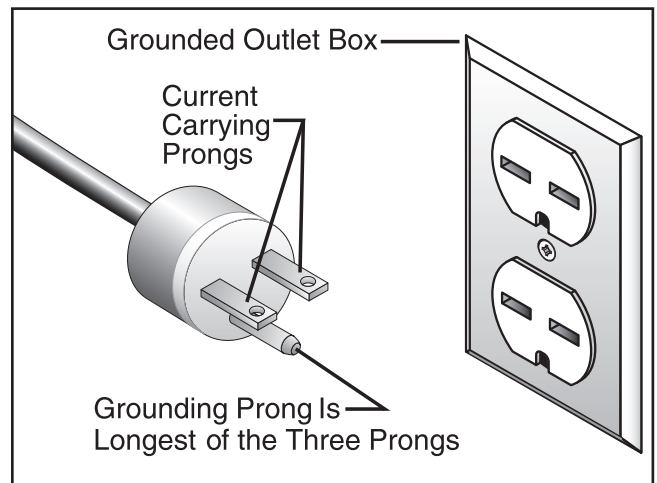



Figure 2. 6-15 plug and outlet.

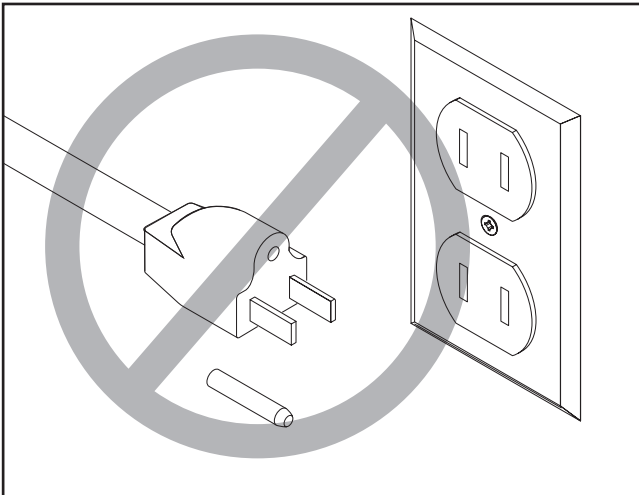


Grounding

In the event of an electrical short, grounding reduces the risk of electric shock. The grounding wire in the power cord must be properly connected to the grounding prong on the plug; likewise, the outlet must be properly installed and grounded. All electrical connections must be made in accordance with local codes and ordinances.



! WARNING
Electrocution or fire could result if this machine is not grounded correctly or if your electrical configuration does not comply with local and state codes. Ensure compliance by checking with a qualified electrician!



! CAUTION
This machine must have a ground prong in the plug to help ensure that it is grounded. **DO NOT** remove ground prong from plug to fit into a two-pronged outlet! If the plug will not fit the outlet, have the proper outlet installed by a qualified electrician.

Extension Cords

We do not recommend the use of extension cords. Instead, arrange the placement of your equipment and the installed wiring to eliminate the need for extension cords.

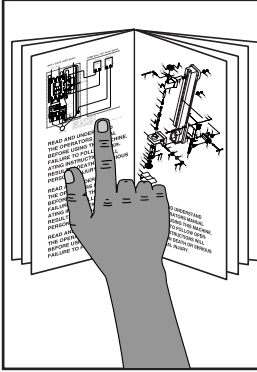
If you find it absolutely necessary to use an extension cord at 110V with your machine:

- Use at least a 10 gauge cord for 110V and 14 gauge cord for 220V that does not exceed 50 feet in length!
- The extension cord must also contain a ground wire and plug pin.
- A qualified electrician **MUST** size cords over 50 feet long to prevent motor damage.

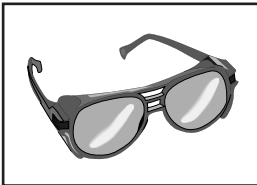


SECTION 3: SET UP

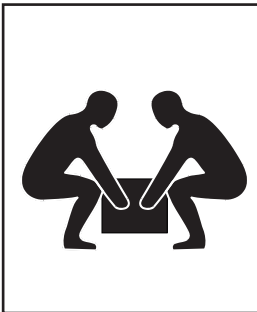
Set Up Safety



!WARNING
This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



!WARNING
Wear safety glasses during the entire set up process!



!WARNING
The Model G9743 is a heavy machine. DO NOT over-exert yourself while unpacking or moving your machine—get assistance.

Items Needed for Set Up

The following items are needed to complete the set up process, but are not included with your machine:

Description	Qty
• Wrench 12mm	1
• Wrench 14mm	1
• Safety Glasses (for each person)	1
• An Assistant	1
• Phillips Head Screwdriver #2	1

Unpacking

The Model G9743 was carefully packed when it left our warehouse. If you discover the machine is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advise.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, you should inventory the contents.



Inventory

After all the parts have been removed from the box, you should have the following items:

Box Contents (Figure 3)		Qty
Metal-Cutting Bandsaw (not shown)		1
A. Wheels		1
B. Wheel Brackets		1
C. Chip Screen		1
D. Work Stop Rod		1
E. Work Stop		1
F. Axles		2

Hardware Bag

—Hex Bolts $\frac{3}{8}$ -16 x $\frac{5}{8}$	2
—Flat Washers $\frac{3}{8}$	2
—Cotter Pins 3 x 25	2
—Hex Bolts $\frac{5}{16}$ -18 x $1\frac{1}{2}$	6
—Hex Nuts $\frac{5}{16}$ -18	6
—Flat Washers $\frac{5}{16}$	12
—Wire Nuts	2
—Thumb Screw	1

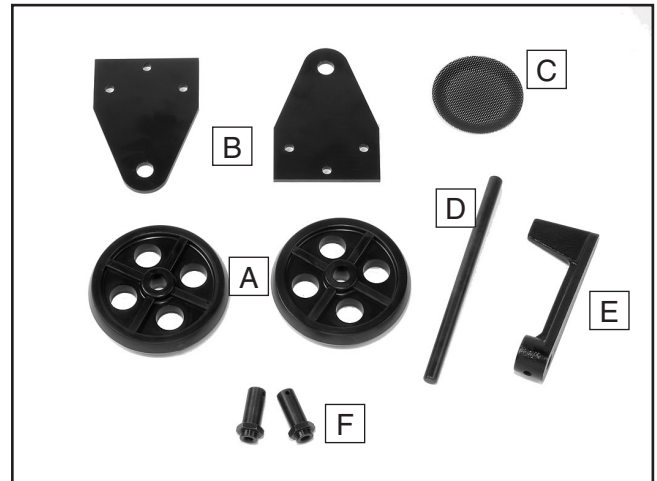


Figure 3. Loose parts inventory.



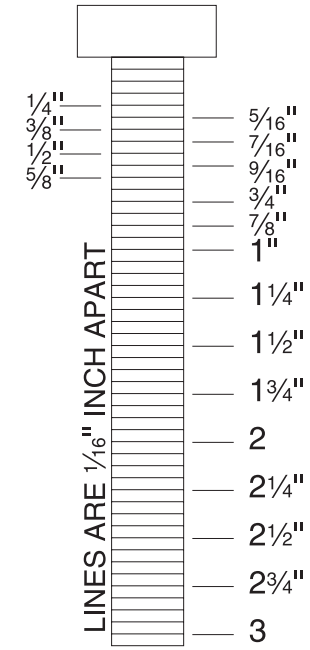
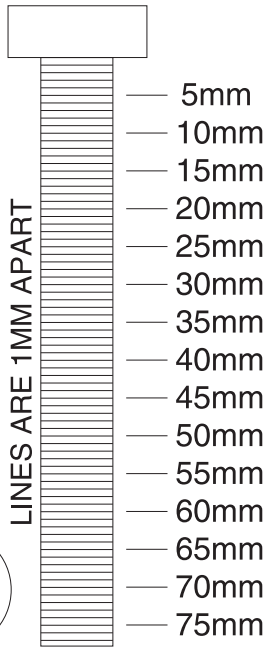
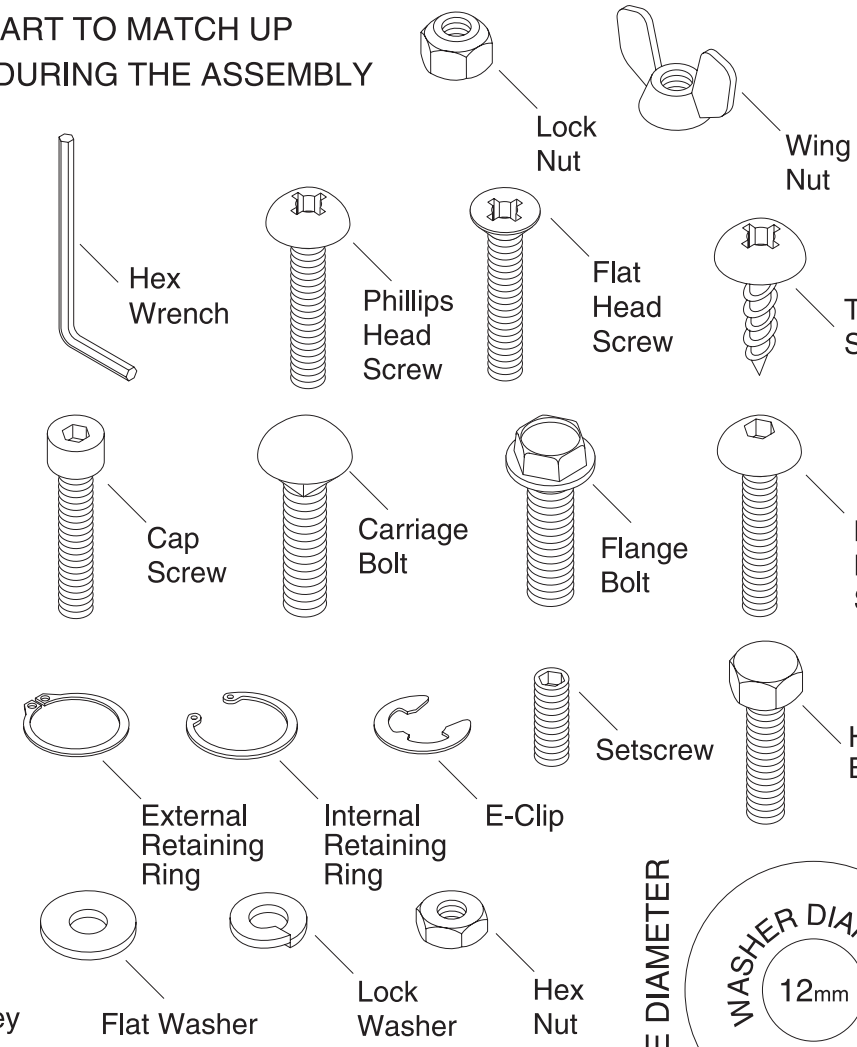
Hardware Recognition Chart

USE THIS CHART TO MATCH UP
HARDWARE DURING THE ASSEMBLY
PROCESS!

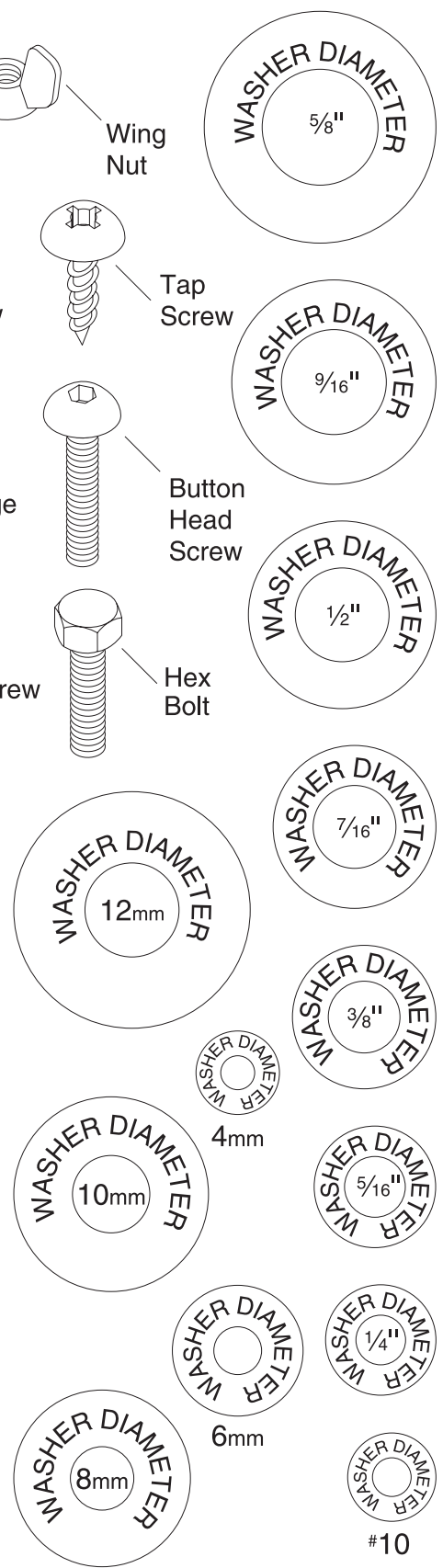
MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

- #10
- 1/4"
- 5/16"
- 3/8"
- 7/16"
- 1/2"

- 4mm
- 6mm
- 8mm
- 10mm
- 12mm
- 16mm




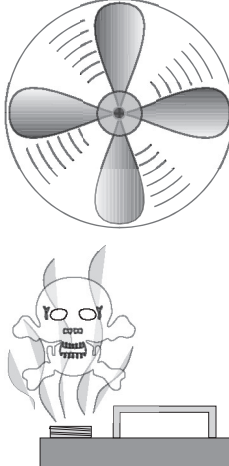
WASHERS ARE MEASURED BY THE INSIDE DIAMETER



Clean Up

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents, such as acetone or brake parts cleaner, as they may damage painted surfaces should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

	<p>⚠️ WARNING Gasoline and petroleum products have low flash points and could cause an explosion or fire if used to clean machinery. DO NOT use gasoline or petroleum products to clean the machinery.</p>
--	--

	<p>⚠️ CAUTION Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Lack of ventilation while using these solvents could cause serious personal health risks or fire. Take precautions from this hazard by only using cleaning solvents in a well ventilated area.</p>
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Site Considerations

Floor Load

The weight and footprint size for your machine is located in the machine data sheet. Most floors are suitable for your machine. Some residential floors may require additional reinforcement to support both the machine and operator.

Working Clearances

Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your new machine. See **Figure 4** for the minimum working clearances.

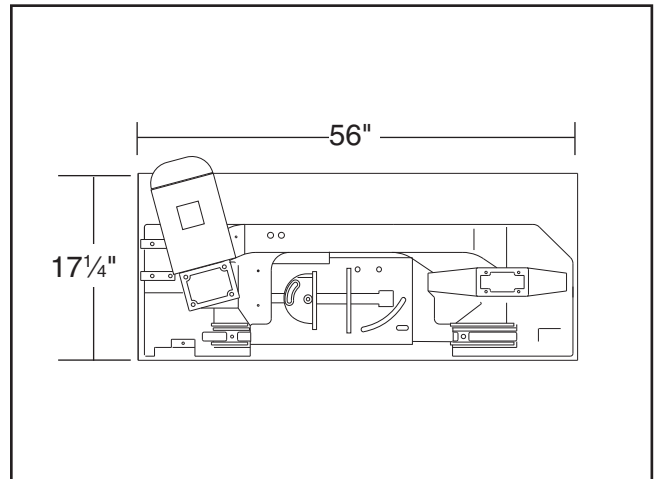


Figure 4. Minimum G9743 working clearances.

	<p>⚠️ CAUTION Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and DO NOT allow unsupervised children or visitors in your shop at any time!</p>
--	--



Shipping Bracket

A shipping bracket has been installed on the bandsaw to protect the alignment of the headstock during shipment. After removal, store the bracket in a safe place until you need to move or ship the bandsaw in the future.

To remove the shipping bracket:

1. Use a 12mm wrench to remove the top hex bolt and flat washer, use a 14mm wrench to loosen the bottom hex nut and remove the shipping bracket shown in **Figure 5**.

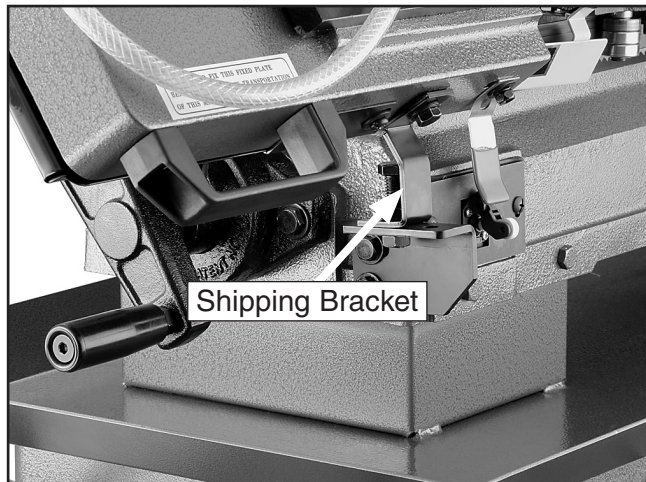


Figure 5. Removing shipping bracket.

Work Stop

Components and Hardware Needed:	Qty
Work Stop.....	1
Work Stop Rod.....	1
Thumb Screw.....	1

To install the work stop:

1. Insert the work stop rod through the hole in the base shown in **Figure 6** and lock in place with the hex bolt.

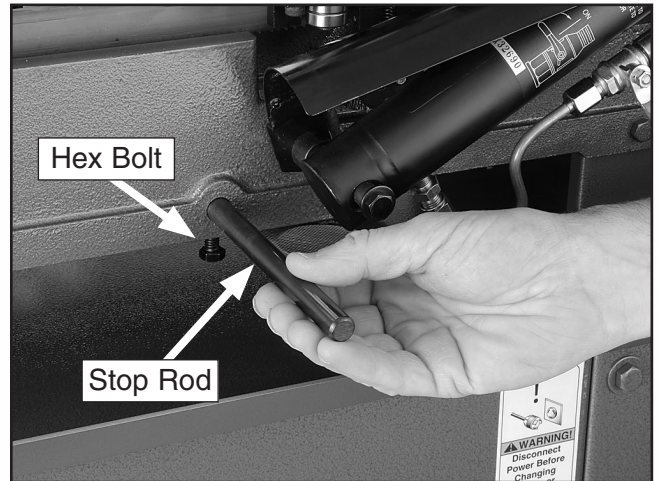


Figure 6. Installing work stop rod.

2. Thread the thumb screw into the work stop and slide the work stop over the rod as shown in **Figure 7**.

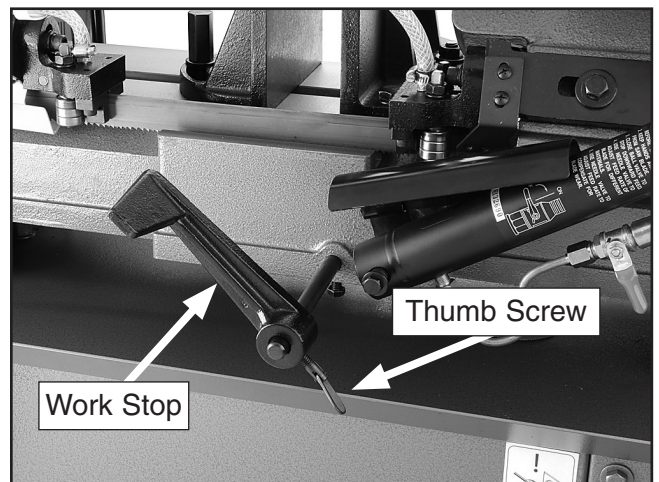


Figure 7. Work stop installed.

3. Tighten the thumbscrew.



Wheels

The wheels may be installed to make it easier to move the G9743 bandsaw.

Components and Hardware Needed:	Qty
Wheels.....	2
Wheel Brackets	2
Axles.....	2
Hex Bolts $\frac{3}{8}$ -16 x $\frac{5}{8}$	2
Flat Washers $\frac{3}{8}$	2
Cotter Pins 3 x 25.....	2
Hex Bolts $\frac{5}{16}$ -18 x $1\frac{1}{2}$	6
Hex Nuts $\frac{5}{16}$ -18	6
Flat Washers $\frac{5}{16}$	12

To install the wheels:

1. Align a wheel bracket with the frame mounting holes and secure with three $\frac{5}{16}$ -18 x $1\frac{1}{2}$ hex bolts, three hex nuts, and six flat washers, as shown in **Figure 8**.

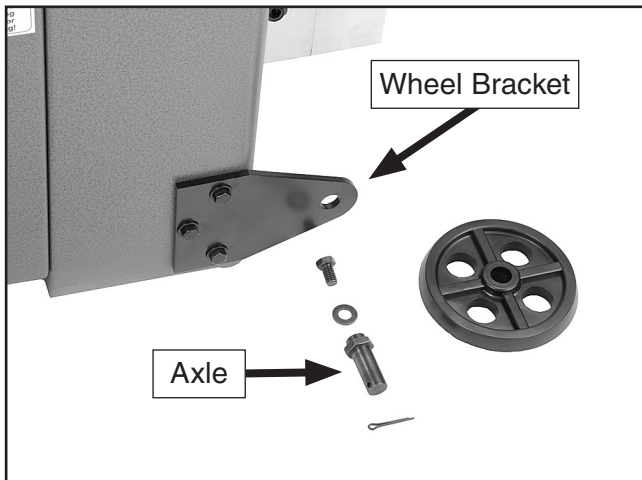


Figure 8. Installing wheel.

2. Insert the threaded end of each axle into the wheel bracket and secure with a $\frac{3}{8}$ -16 x $\frac{5}{8}$ hex bolt and a flat washer.
3. Slide a wheel over the axle.
4. Insert a cotter pin into the axle, and spread the pin to secure the wheel.
5. Install the opposite wheel, repeating **Steps 1-4**.

Chip Screen

The chip screen is designed to prevent chips and cut-offs from entering the coolant tank.

Components and Hardware Needed:	Qty
Chip Screen.....	1

To install the chip screen:

1. Place the chip screen into the opening shown in **Figure 9**.

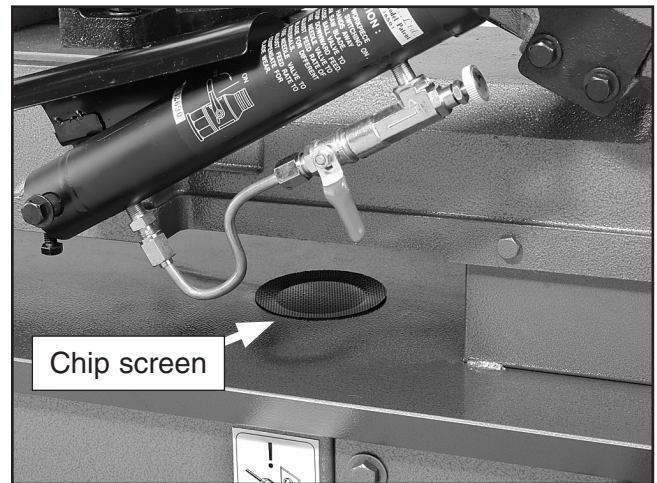
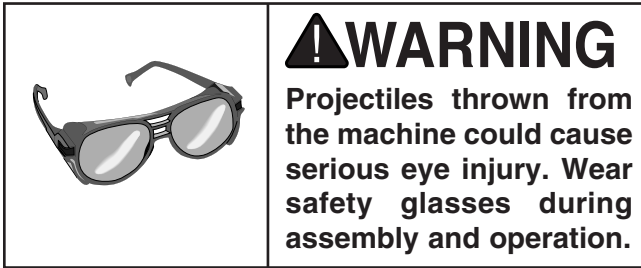


Figure 9. Chip screen installed.



Test Run



Starting the machine:

1. Read the entire instruction manual.
2. Make sure all tools and foreign objects have been removed from the machine.
3. Put on safety glasses and secure loose clothing or long hair.
4. Connect the bandsaw to power.
5. Raise the bandsaw and close the feed ON/OFF valve to keep the saw in place (see **Figure 10**).

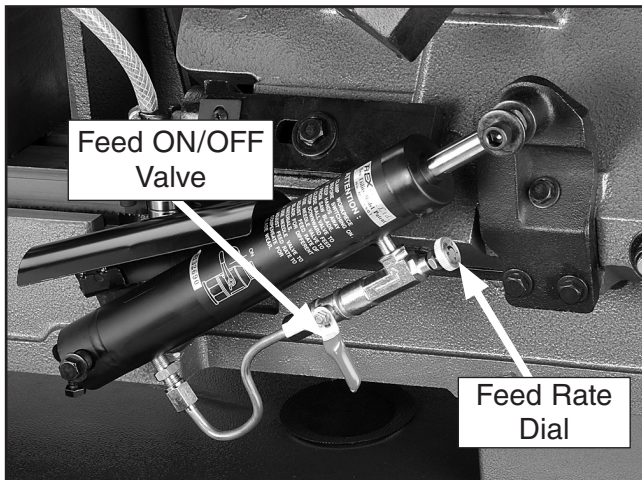


Figure 10. Feed ON/OFF valve and feed rate dial.

6. Start the bandsaw while keeping your finger near the ON/OFF switch at all times during the test run (**Figure 11**). The bandsaw should run smoothly with little or no vibration.

Note: If the **EMERGENCY STOP** button is pressed, it needs to be twisted until it pops out or the bandsaw will not start.

—If you suspect any problems, immediately stop the bandsaw and correct before continuing.

—If you need any help with your bandsaw call our Tech Support at (570) 546-9663.



Figure 11. ON/OFF switch.

Recommended Adjustments

The adjustments listed below have been performed at the factory. However, because of the many variables involved with shipping, we recommend that you at least verify the following adjustments to ensure accurate cutting results.

Step-by-step instructions on verifying these adjustments can be found in **SECTION 7: SERVICE ADJUSTMENTS**.

Factory adjustments that should be verified:

1. Blade Tracking (**Page 33**).
2. Squaring the Blade (**Page 34**).
3. Blade Guide Bearings (**Page 35**).

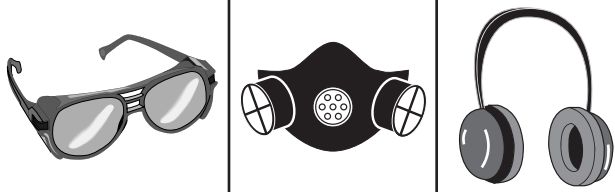


SECTION 4: OPERATIONS

Operation Safety

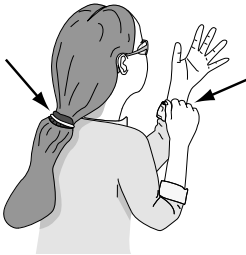
!WARNING

Damage to your eyes, lungs, and ears could result from using this machine without proper protective gear. Always wear safety glasses, a respirator, and hearing protection when operating this machine.



!WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing and long hair away from moving machinery.



NOTICE

If you have never used this type of machine or equipment before, WE STRONGLY RECOMMEND that you read books, trade magazines, or get formal training before beginning any projects. Regardless of the content in this section, Grizzly Industrial will not be held liable for accidents caused by lack of training.

Vise

The vise on the Model G9743 has a positive locking feature that improves productivity by opening the vise jaws just enough to slide material through.

To use the positive lock:

1. Raise the headstock above the workpiece and lock in place.
2. Place the vise handle in the half open position (45°). See **Figure 12**.
3. Place the workpiece between the jaws and turn the handwheel until the rear jaw makes contact with the workpiece.
4. Push the positive lock handle down to the lock position (0°). As you do this you will feel the handle tighten against the workpiece (see **Figure 12**).
5. To loosen the workpiece, lift the vise handle to the fully open position (90°).
6. Slide the stock to the workstop for your next cut. The vise position will not change as long as you don't change the position of the vise jaws with the handwheel.

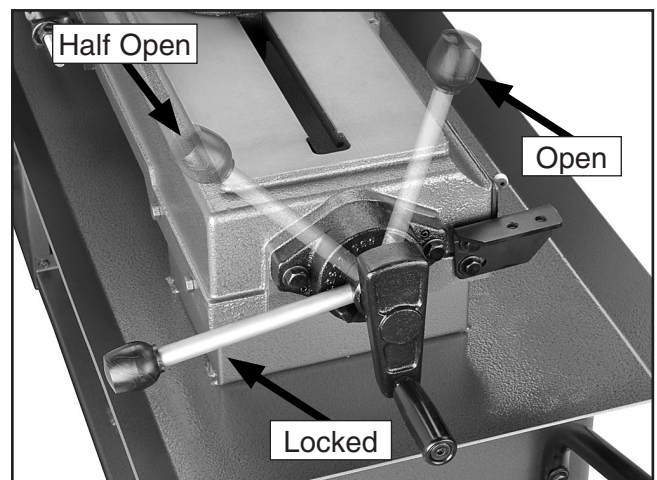


Figure 12. Positive locking handle positions.



To adjust the angle on the vise:

1. Loosen the lock nut with a $\frac{3}{4}$ " hex wrench.
2. Use the scale as a guide to set your angle or use a machinist square to square the vise to the blade as shown in **Figure 13**.
3. Tighten the lock nut.

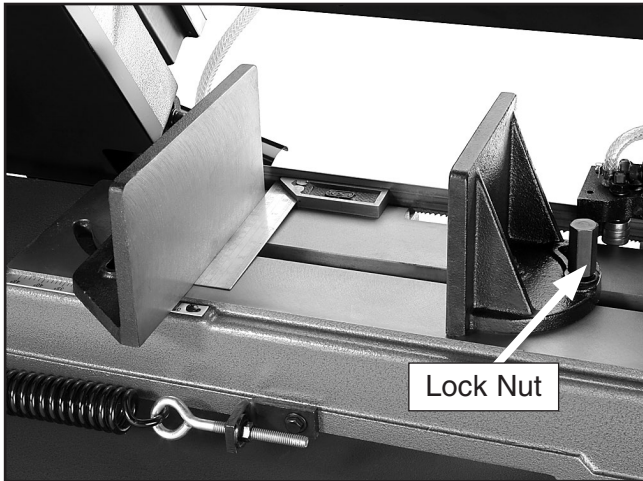


Figure 13. Squaring vise to blade.

4. Loosen the lock nut in **Figure 14** on the opposite jaw so the jaw can float, and match the angle of the workpiece.
5. Tighten the vise against the workpiece.

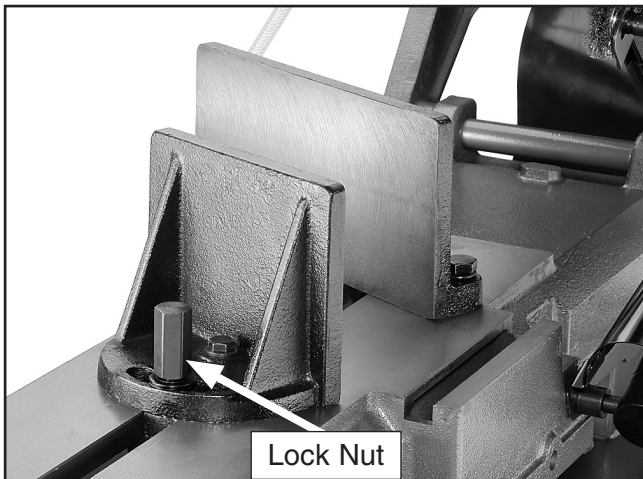


Figure 14. Vise jaw lock-nut.

Blade Speed

The Model G9743 has these three blade speeds: 148, 216, and 282 FPM.

NOTICE

DO NOT change speeds when the motor is running. Wait for the bandsaw to come to a complete stop or you will damage the gears and you will void your warranty.

To change blade speeds:

1. TURN THE BANDSAW **OFF** AND ALLOW IT TO COME TO A COMPLETE STOP.
2. Determine the best speed for your cut. The table in **Figure 15** is provided as a rough guideline. Material thickness, type of blade used and if cutting fluid is used, will factor into the correct speed selection. As a general rule, add 15% when using cutting fluid.

Material	Feet Per Minute (FPM)
Tool, Stainless, & Alloy Steels, Cast Iron	148
Medium to High Carbon Steels, Iron, Hard Brass or Bronze	216
Aluminum and Plastics	282

Figure 15. Blade speed table.

Continued on next page →



3. With the saw turned **OFF**, rotate the speed control knob to the desired position (see **Figure 16**).



Figure 16. Speed control knob.

Blade Selection

The Model G9743 uses 104½ x 1" bandsaw blades.

Selecting the right blade for the job depends on a variety of factors, such as the type of material being cut, hardness of the material, machine capability, and operator technique.

We suggest you do some research for your specific situation so you get the best blade to match your needs.

Grizzly is proud to offer a variety of selections that can be found in the current catalog and in **SECTION 5: ACCESSORIES** on **Page 26**.

Cutting Fluid System

This bandsaw has a built-in cutting fluid system that extends the life of your bandsaw blades by lowering the temperature of the blade and workpiece and washing away chips.

See **Cutting Fluid** on **Page 22** for more information.

To use the cutting fluid system:

1. Thoroughly clean and remove any foreign material that may have fallen inside the reservoir during shipping.
2. Place the filter screen and drain tube in the reservoir as shown in **Figure 17**.
3. Fill the reservoir to the "high" mark with your chosen cutting fluid solution.

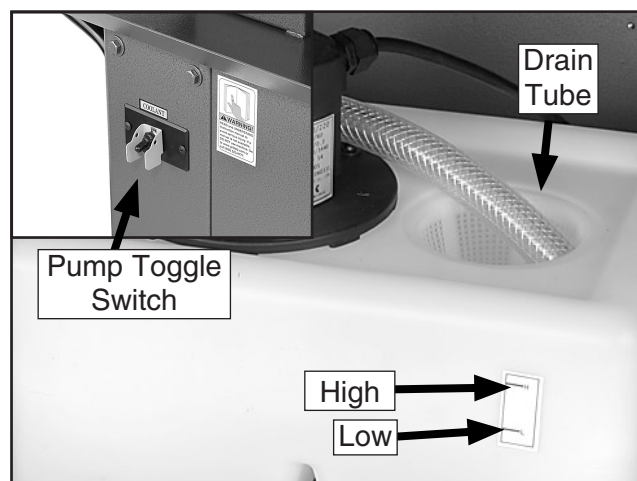



Figure 17. Filter screen and hose.

	<p>! WARNING</p> <p>FIRE HAZARD! DO NOT cut magnesium when using oil-water solutions as a cutting fluid! Always use a cutting fluid intended for magnesium. The water in the solution will cause a magnesium-chip fire.</p>
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- Adjust the valve on the coolant hose to control the flow of coolant (see **Figure 18**). Make sure that the pressure is not so high that coolant spills on the floor and creates a slipping hazard.

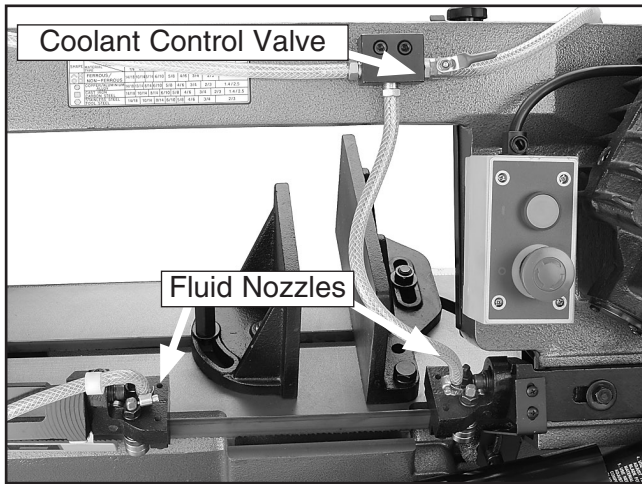


Figure 18. Coolant control valve.

- Turn the pump toggle switch **ON** before making your cut.

NOTICE

Keep the tray chip screen clear so coolant can recycle to the pump reservoir. **NEVER** operate the pump with the reservoir below the low mark or you will over-heat the pump and void your warranty!

Cutting Fluid

While simple in concept and function, many issues must be taken into account to find and use the correct cutting fluid. Always follow all product warnings and contact the fluid manufacturer for unanswered questions.

Use the selections below to choose the appropriate cutting fluids:

- For cutting low alloy, low carbon, and general-purpose category metals with a bi-metal blade—use a water soluble cutting fluid.
- For cutting stainless steels, high carbon, and high alloy metals, brass, copper and mild steels—use "Neat Cutting Oil" (commonly undiluted mineral oils) that have extreme pressure additives (EP additives).
- For cutting cast iron, cutting fluid is not recommended.

Remember: Too much flow at the cutting fluid nozzle will make a mess and can make the work area unsafe; and not enough fluid at the cut will heat the blade, causing the blade teeth to load up and break.

	<p>!WARNING BIOLOGICAL AND POISON HAZARD! Use proper personal protection equipment when handling cutting fluid and dispose by following federal, state, and fluid manufacturer requirements to properly dispose of cutting fluid.</p>
--	--



Blade Guides

The blade guides should be as close to the workpiece as possible. This will help ensure straight cuts by keeping the blade from twisting and drifting off the cut line.

To adjust the blade guides:

1. Loosen the knob shown in **Figure 19** and slide the rear blade guide as close to the workpiece as possible, then tighten the knob.

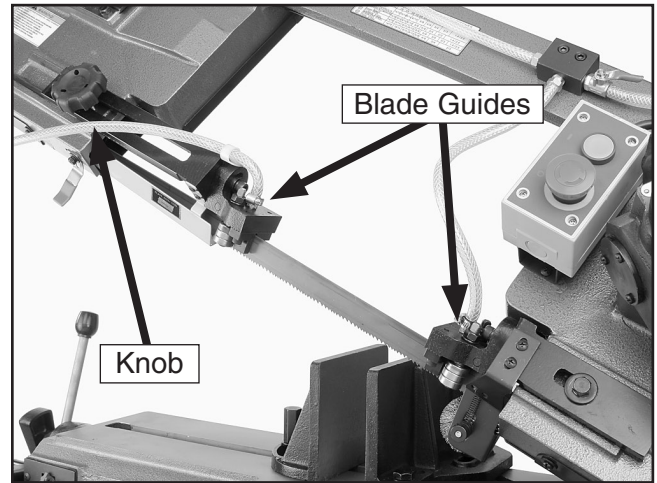


Figure 19. Blade guides.



Feed Rate

The speed at which the saw blade will cut through a workpiece is controlled by blade type, feed rate, and feed pressure.

Note: If a lubricant is used on the cut, the feed rate can be increased by approximately 15%.

To set the feed rate:

1. Raise the headstock to the maximum height to remove spring tension. Close the ON/OFF valve to lock the headstock in place.
2. Using a 14mm wrench, adjust the feed pressure tension spring. Tighten enough to remove play but not enough to apply tension to the spring (see **Figure 20**).

Note: This spring adjustment is an initial setting. Depending on cutting circumstances, you will have to fine-tune the feed pressure with this adjustment. Increasing the spring tension will reduce the feed pressure.

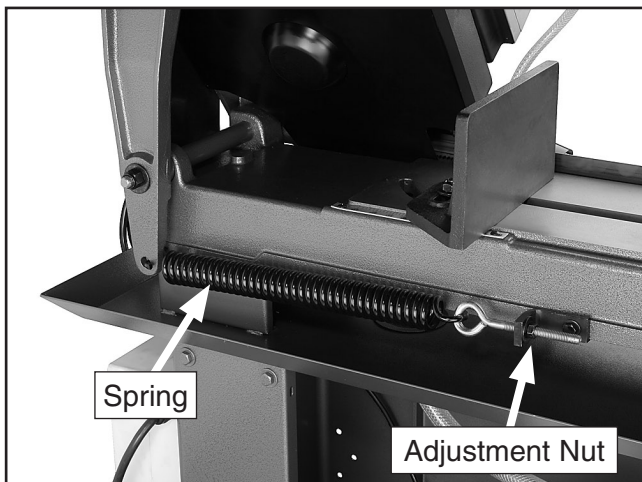


Figure 20. Spring tension adjustment.

3. Clamp the workpiece in the table vise.
4. Close the feed ON/OFF valve **Figure 21**, to lock the headstock and blade a few inches above the workpiece.

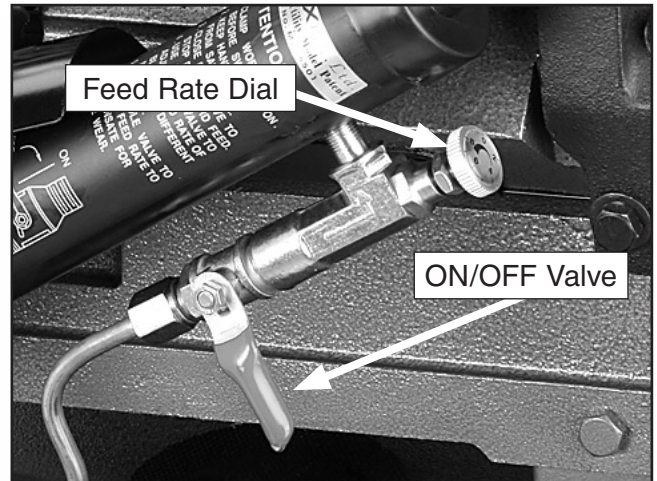


Figure 21. Feed rate dial.

5. With the correct saw blade and blade speed selected, turn the saw and lubricant pump **ON**.
6. Slowly rotate the feed rate dial clockwise to a slow feed rate until the saw begins to cut the workpiece (see **Figure 21**).
7. Observe the chips that exit the cut, and increase or decrease the feed rate according to the chip characteristics (see **Figure 22**).

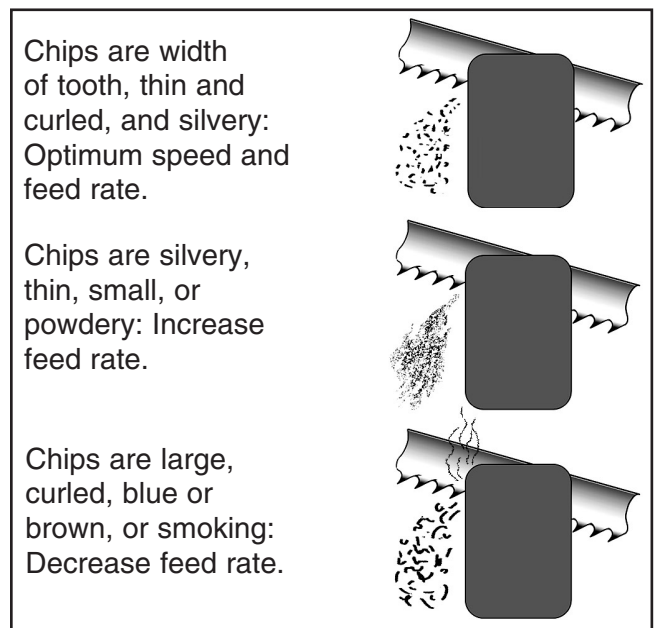


Figure 22. Reading chip characteristics.



Operation Tips

The following tips will help you safely and effectively operate your bandsaw, and help you get the maximum life out of your saw blades.

Tips for horizontal cutting:

- Use the work stop to quickly and accurately cut multiple pieces of stock to the same length.
- Clamp the material firmly in the vise jaws to ensure a straight cut through the material and use the positive lock to speed production.
- Let the blade reach full speed before engaging the workpiece. Never start a cut with the blade in contact with the workpiece (see **Figure 24**).
- Chips should be curled and silvery. If the chips are thin and powder like, increase your feed rate.
- Burned chips indicate a need to reduce your blade speed.
- Wait until the blade has completely stopped before removing the workpiece from the vise, and avoid touching the cut end—it could be very hot!
- Support long pieces so they won't fall when cut, and flag the end to alert passers-by of potential danger.
- Adjust the blade guides as close as possible to the workpiece to minimize side-to-side blade movement.
- Use coolant when possible to increase blade life.

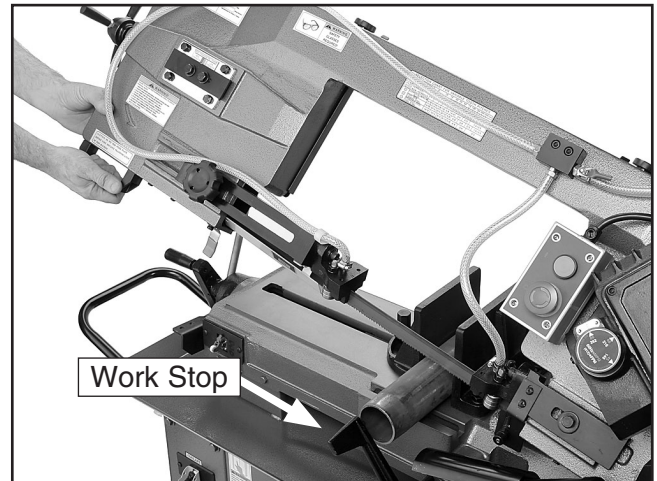


Figure 24. Proper starting position.



SECTION 5: ACCESSORIES

- H2307—104-1/2 x 1 x .032 10 TPI Raker
- H2308—104-1/2 x 1 x .032 14 TPI Raker
- H2315—104-1/2 x 1 x .032 3-4 Variable Pitch
- H2316—104-1/2 x 1 x .032 4-6 Variable Pitch
- H2317—104-1/2 x 1 x .032 5-8 Variable Pitch
- H2318—104-1/2 x 1 x .032 6-10 Variable Pitch
- H2319—104-1/2 x 1 x .032 8-12 Variable Pitch
- H2320—104-1/2 x 1 x .032 10-14 Variable Pitch

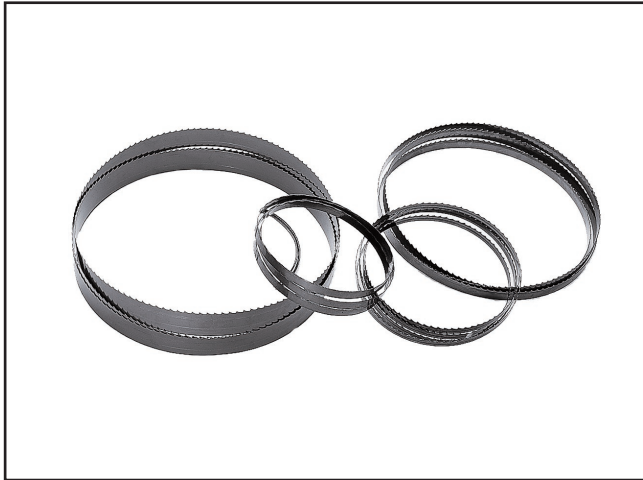


Figure 25. Blades

H5408—Blade Tensioning Gauge

The Blade Tensioning Gauge ensures long blade life, reduced blade breakage, and straight cutting by indicating correct tension. A precision dial indicator provides you with a direct readout in PSI.



Figure 26. H5408 Blade Tensioning Gauge.

H5405—Lenox® Lube Tube™

Lenox® Lube Tube™ is a stick lubricant designed to prevent heat buildup. Apply it directly to the blade to improve overall blade life and productivity. Can be used on ferrous and non-ferrous metals. Biodegradable, non-toxic, and non-staining 14.5 oz tube.



Figure 27. Lenox® Lube Tube™.

G7897—Machining Fluid This biostable, soluble oil for heavy-duty machining applications provides stable pH performance which resists bacteria and fungal growth, rancidity and odors. Can be used in light or heavy machining Mix with water, 1:21 for general use or 1:11-1:16 for heavy use.



Figure . G7897 Machining Fluid.

Call 1-800-523-4777 To Order



- G5618—Deburring Tool w/2 Blades**
- G5619—Extra Aluminum Blades**
- G5620—Extra Brass and Cast Iron Blade**

The quickest tool for smoothing freshly machined metal edges. Comes with two blades—one for steel/aluminum and one for brass/cast iron.



Figure 28. G5618 Deburring tool.

- G7984—Face Shield**
- H1298—Dust Sealed Safety Glasses**
- H1300—UV Blocking, Clear Safety Glasses**
- H2347—Uvex® Spitfire Safety Glasses**
- H0736—Shop Fox® Safety Glasses**

Safety Glasses are essential to every shop. If you already have a pair, buy extras for visitors or employees. You can't be too careful when it comes to shop safety!



Figure 29. Our most popular safety glasses.

- H1302—Standard Earmuffs**
 - H4979—Deluxe Twin Cup Hearing Protector**
 - H4977—Work-Tunes Radio Headset Earmuffs**
- Protect yourself comfortably with a pair of cushioned earmuffs. Especially important if you or employees operate for hours at a time.



Figure 30. Our most popular earmuffs.

- G9256—6" Dial Caliper**
- G9257—8" Dial Caliper**
- G9258—12" Dial Caliper**

These traditional dial calipers are accurate to 0.001" and can measure outside surfaces, inside surfaces, and heights/depths. Features stainless steel, shock resistant construction and a dust proof display.

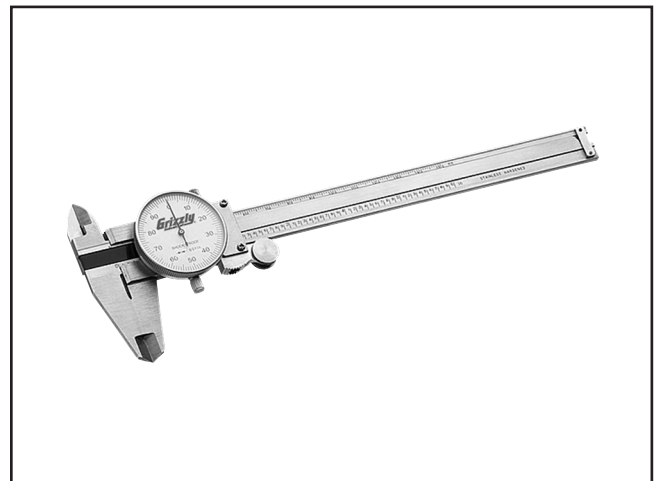
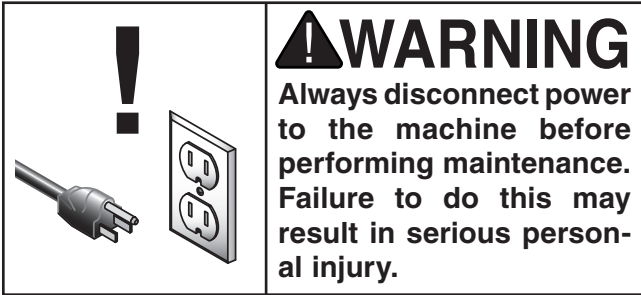


Figure 31. Grizzly® Dial Calipers.

Call 1-800-523-4777 To Order



SECTION 6: MAINTENANCE



Schedule

For optimum performance from your machine, follow this maintenance schedule and refer to any specific instructions given in this section.

Daily Check:

- Loose mounting bolts.
- Damaged saw blade.
- Worn or damaged wires.
- Any other unsafe condition.
- Clean after each use.
- Proper blade tension.

Monthly Check:

- Lubricate vise screw.
- Check gear box fluid level.

Annual Check:

- Change gear box oil (every three months if being used daily).

Cleaning

Cleaning the Model G9743 is relatively easy. After using your bandsaw, remove excess chips by sweeping and remove any excess coolant with a dry towel.

Lubrication

Before applying lubricant to any area, wipe the area clean to avoid contamination. Lubricate the vise screw shown in **Figure 32** with general purpose grease.

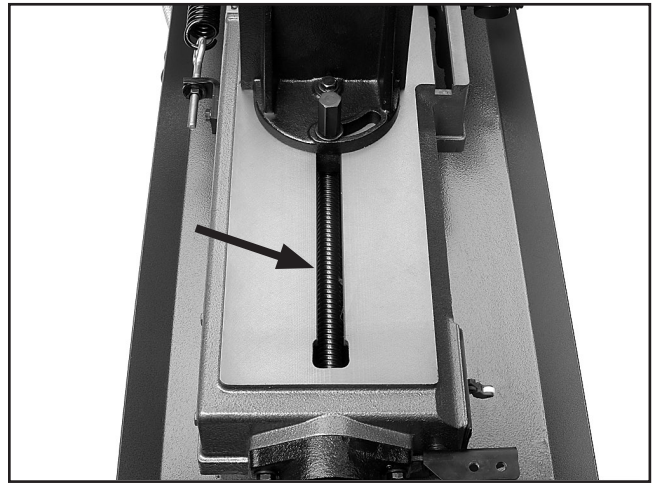


Figure 32. Vise screw lubrication area.

Change gear box oil by removing the drain plug on the underside of the gear box (out of view) in **Figure 33** and drain the gearbox. Replace the drain plug and refill through the fill cap with SAE-30 oil. Fill to the mark indicated on the sight glass.

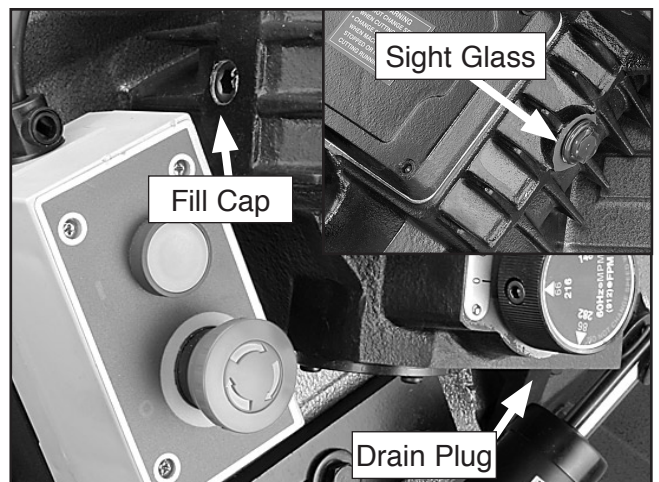


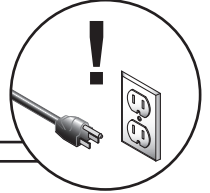
Figure 33. Gear box lubrication.



SECTION 7: SERVICE

Review the troubleshooting and procedures in this section to fix your machine if a problem develops. If you need replacement parts or you are unsure of your repair skills, then feel free to call our Technical Support at (570) 546-9663.

Troubleshooting

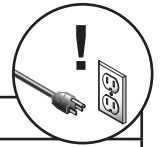


Motor & Electrical

Symptom	Possible Cause	Possible Solution
Machine does not start or a breaker trips.	<ol style="list-style-type: none"> 1. E-Stop button pressed. 2. Plug/receptacle is at fault or wired incorrectly. 3. Start capacitor is at fault. 4. Wall fuse/circuit breaker is blown/tripped. 5. Motor connection wired incorrectly. 6. Power supply is at fault/switched OFF. 7. Motor ON/OFF switch is at fault. 8. Wiring is open/has high resistance. 9. Motor is at fault. 	<ol style="list-style-type: none"> 1. Twist E-Stop button until it pops out. 2. Test for good contacts; correct the wiring. 3. Test/replace if faulty. 4. Ensure correct size for machine load; replace weak breaker. 5. Correct motor wiring connections. 6. Ensure hot lines have correct voltage on all legs and main power supply is switched ON. 7. Replace faulty ON/OFF switch. 8. Check for broken wires or disconnected/corroded connections, and repair/replace as necessary. 9. Test/repair/replace.
Machine stalls or is underpowered.	<ol style="list-style-type: none"> 1. Wrong blade for the workpiece material. 2. Wrong workpiece material. 3. Feed rate/cutting speed too fast for task. 4. Blade is slipping on wheels. 5. Low power supply voltage. 6. Motor bearings are at fault. 7. Plug/receptacle is at fault. 8. Motor connection is wired incorrectly. 9. Motor has overheated. 10. Motor is at fault. 	<ol style="list-style-type: none"> 1. Use blade with correct properties for your type of cutting. 2. Use metal with correct properties for your type of cutting. 3. Decrease feed rate/cutting speed. 4. Adjust blade tracking and tension. 5. Ensure hot lines have correct voltage on all legs. 6. Test by rotating shaft; rotational grinding/loose shaft requires bearing replacement. 7. Test for good contacts; correct the wiring. 8. Correct motor wiring connections. 9. Clean off motor, let cool, and reduce workload. 10. Test/repair/replace.
Machine has vibration or noisy operation.	<ol style="list-style-type: none"> 1. Motor fan is rubbing on fan cover. 2. Blade is at fault. 3. Gearbox is at fault. 4. Wrong blade & too slow of speed. 	<ol style="list-style-type: none"> 1. Replace dented fan cover; replace loose/damaged fan. 2. Replace/resharpen blade. 3. Rebuild gearbox for bad gear(s)/bearing(s). 4. Change blade and or speed.



Bandsaw Operations



SYMPTOM	POSSIBLE CAUSE	CORRECTIVE ACTION
Machine is loud when cutting or bogs down in the cut.	<ol style="list-style-type: none"> 1. Excessive feed rate. 2. The blade TPI is too great, or the material is too coarse. 	<ol style="list-style-type: none"> 1. Refer to Feed Rate on Page 24, or Changing Blade Speed on Page 20, and adjust as required. 2. Refer to Blade Selection on Page 21 and adjust as required.
Blades break often.	<ol style="list-style-type: none"> 1. Blade is not tensioned correctly. 2. The workpiece is loose in the vise. 3. The feed or cut speed is wrong. 4. The blade TPI is too great, or the material is too coarse. 5. The blade is rubbing on the wheel flange. 6. The bandsaw is being started with the blade resting on the workpiece. 7. The guide bearings are misaligned, or the blade is rubbing on the wheel flange. 8. The blade is too thick, or the blades are of low quality. 	<ol style="list-style-type: none"> 1. Check to see that blade is not excessively tight or too loose. 2. Clamp the workpiece tighter, or use a jig to hold the workpiece. 3. Refer to Feed Rate on Page 24, or Changing Blade Speed on Page 20, and adjust as required. 4. Refer to Blade Selection on Page 21, and adjust as required. 5. Refer to Blade Tracking on Page 33, and adjust as required. 6. Start bandsaw and then slowly lower the headstock by setting the feed rate. 7. Refer to Blade Tracking on Page 33, or Blade Guides on Page 23, and adjust as required. 8. Use a higher quality blade.
Blade dulls prematurely.	<ol style="list-style-type: none"> 1. The cutting speed is too fast. 2. The blade TPI is too coarse. 3. The blade feed pressure is too light. 4. The workpiece has hard spots, welds, or scale is on the material. 5. The blade is twisted. 6. The blade is slipping on the wheels. 	<ol style="list-style-type: none"> 1. Refer to Changing Blade Speed on Page 20, and adjust as required. 2. Refer to Blade Selection on Page 21, and adjust as required. 3. Refer to Feed Rate on Page 24, and adjust as required. 4. Increase the feed pressure, and reduce the cutting speed. 5. Replace the blade. 6. Refer to Blade Tension on Page 34, and adjust as required.
Blade wears on one side.	<ol style="list-style-type: none"> 1. The blade guides are worn or mis-adjusted. 2. The blade guide slide bracket is loose. 3. The wheels are out of alignment. 	<ol style="list-style-type: none"> 1. Refer to Blade Guides on Page 23 and replace or adjust. 2. Tighten the blade guide bracket. 3. Refer to Blade Tracking on Page 33, and adjust as required.
Teeth are ripping from the blade.	<ol style="list-style-type: none"> 1. The feed pressure is too heavy and the blade speed is too slow; or the blade TPI is too coarse for the workpiece. 2. The workpiece is vibrating in the vise. 3. The blade gullets are loading up with chips. 	<ol style="list-style-type: none"> 1. Refer to Blade Selection on Page 21 and decrease the feed pressure. Refer to Feed Rate on Page 24, and adjust as required. 2. Re-clamp the workpiece in the vise, and use a jig if required. 3. Use a coarser-tooth blade.
The cuts are crooked.	<ol style="list-style-type: none"> 1. The feed pressure is too high. 2. The guide bearings are out of adjustment, or too far away from the workpiece. 3. The blade tension is low. 4. The blade is dull. 5. The blade speed is wrong. 	<ol style="list-style-type: none"> 1. Refer to Feed Rate on Page 24, and adjust as required. 2. Refer to Blade Guides on Page 23 and replace or adjust. 3. Refer to Blade Tension on Page 34, and adjust as required. 4. Refer to Changing the Blade on Page 32 and replace the blade. 5. Refer to Changing Blade Speed on Page 20, and adjust as required.



Blade Change

Blades should be changed when they become dull, damaged, or when you are using materials that require a blade of a certain type or tooth count.

To change the blade on the bandsaw:

1. UNPLUG THE BANDSAW!
2. Raise the headstock of the bandsaw to the highest position, close the Feed ON/OFF valve, and remove the wheel access cover.
3. Remove the blade guards.
4. Loosen the tension handle in **Figure 34** and slip the blade off of the wheels.

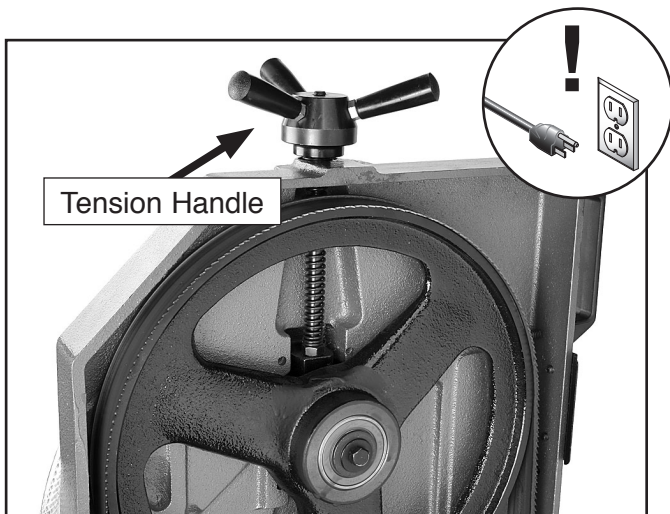


Figure 34. Tension handle and blade.

4. Install the new blade through both blade guide bearings, as shown in **Figure 35**, and around the bottom wheel.

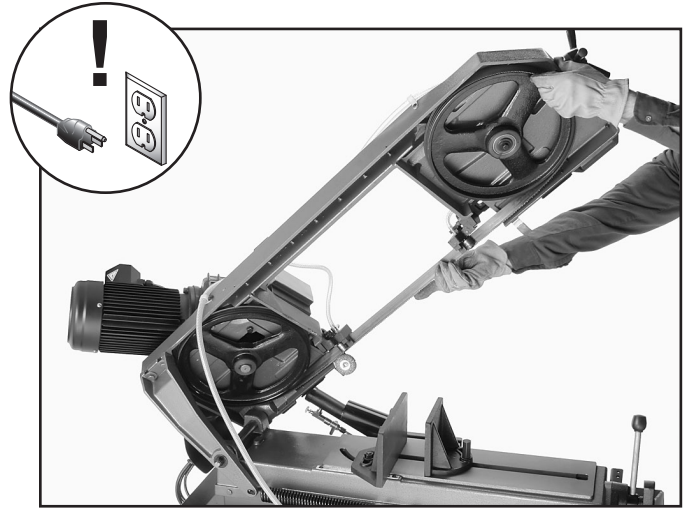


Figure 35. Installing blade.

5. Hold the blade around the bottom wheel with one hand and slip it around the top wheel with the other hand, keeping the blade between the blade guide bearings.

Note: It is sometimes possible to flip the blade inside out, in which case the blade will be installed in the wrong direction. Check to make sure the blade teeth are facing toward the workpiece, as shown in **Figure 36**, after mounting on the bandsaw. Some blades will have a directional arrow as a guide.

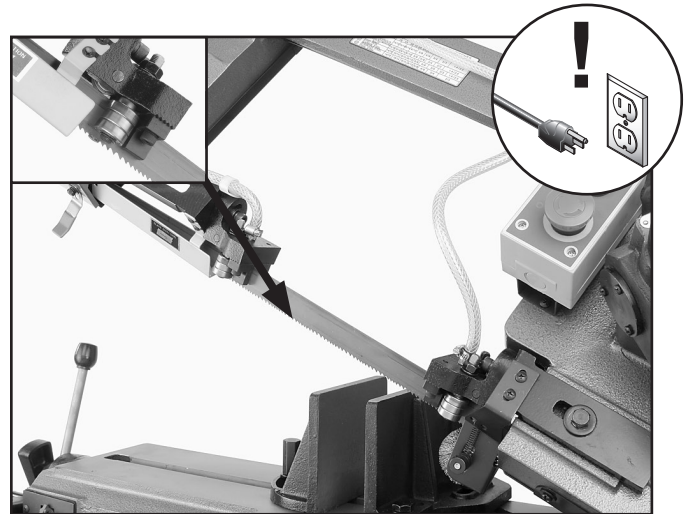


Figure 36. Blade cutting direction.

6. When the blade is around both wheels, adjust the position so the back of the blade is against the shoulder of the wheels.



7. Tighten the tension handle as tight as necessary so the blade will not slip on the wheels during start up.
8. Put the gearbox in neutral by moving the gear change knob between two of the speed positions.
9. Spin the wheel by hand until the blade resumes the previous tracking.
10. Put the gearbox back in gear.

—If the tracking needs to be adjusted, refer to the **Tracking** procedure in the next section.

—If the tracking is fine, proceed to **Blade Tension** on **Page 34**.

Blade Tracking

The blade tracking has been properly set at the factory. The tracking will rarely need to be adjusted if the bandsaw is used properly.

To adjust the blade tracking on the bandsaw:

1. UNPLUG THE BANDSAW!
2. Raise the bandsaw to the highest position and close the feed rate ON/OFF valve.
3. Remove both blade guide assemblies.
4. Open the wheel access cover.
5. Loosen, but do not remove the lower cap screw in the blade wheel tilting mechanism (**Figure 37**).

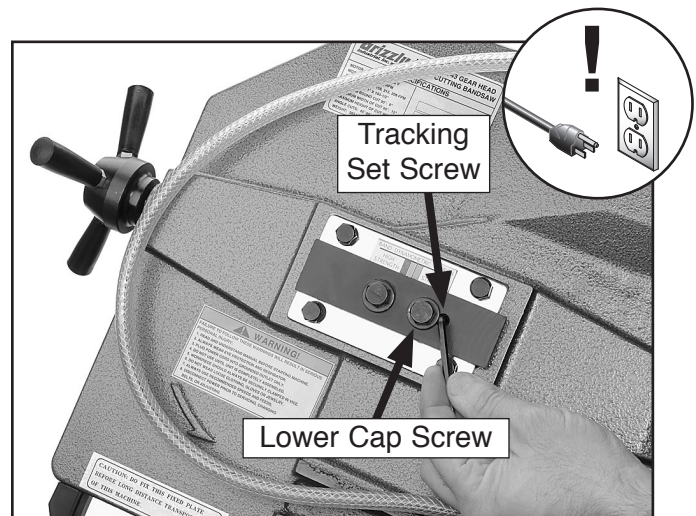


Figure 37. Adjusting tracking set screw.

6. Relax the blade tension.
7. Adjust the tracking set screw with a 4mm hex wrench as shown in **Figure 37**, then tighten the cap screw loosened in **Step 4**.
 - Tightening the set screw will move the blade closer to the shoulder of the wheel.
 - Loosening the set screw will move the blade away from the shoulder.
8. Tension the blade.
9. Put the gearbox in neutral by moving the gear change knob between two of the speed positions and spin the wheel by hand.
 - If the blade tracks along the shoulder of the wheel (without rubbing), the blade is tracking properly and this adjustment is completed.
 - If the blade drifts away from the shoulder of the wheel or hits the shoulder, repeat **Steps 4-7**.
10. Replace the blade guard and blade guide assemblies.
11. Adjust the blade guides as needed. Refer to **Blade Guide Bearings** on **Page 35**.



Blade Tension

Proper blade tension is essential to long blade life, straight cuts, and efficient cutting. The Model G9743 features a blade tension indicator to assist you with blade tensioning.

Two major signs that you do not have proper blade tension are: 1) the blade stalls in the cut and slips on the wheels, and 2) the blade frequently breaks from being too tight.

To tension the blade on the bandsaw:

1. Make sure the blade is tracking properly.
2. UNPLUG THE BANDSAW!
3. Slide the blade guides as far apart as they will go, then tighten them down again.
4. Turn the tension handle clockwise to tighten the blade.
5. Tighten the blade until the tension indicator moves into the green or center section of the indicator.
6. To fine tune blade tension, use a blade tensioning gauge, like the one found in **SECTION 5: ACCESSORIES** on **Page 26**. Please follow the instructions included with your gauge and the blade manufacturer's recommendations on blade tension.

Squaring the Blade

It is always a good idea during the life of your saw to check and adjust this setting. This adjustment will improve your cutting results and extend the life of your blade.

To square the blade to the bed of the table:

1. UNPLUG THE BANDSAW!
2. Lower the head of the bandsaw all the way until it contacts the horizontal stop.
3. Place a square on the table bed and against the edge of the blade (**Figure 38**), and check different points along the length of the table between the blade guides.
4. Loosen the cap screw shown in **Figure 38**, and rotate the blade guide until the blade is vertical to the bed, then tighten the cap screws.

Note: Both blade guides can be adjusted to achieve the results you want.

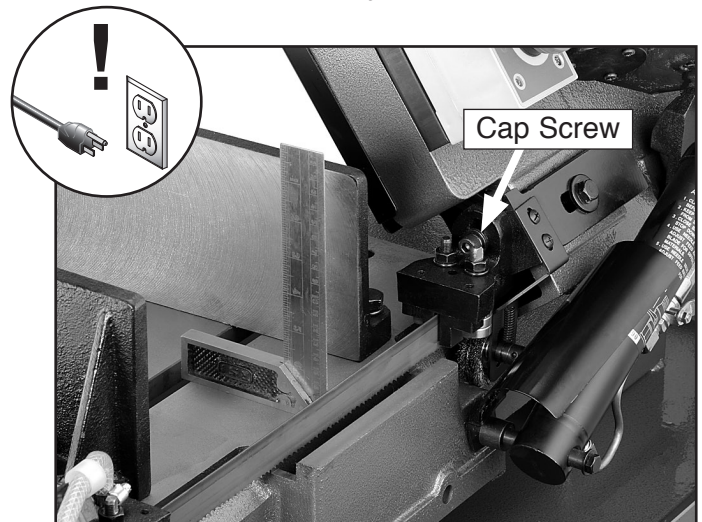


Figure 38. Squaring the blade.



Blade Guide Bearings

The blade guide bearings come adjusted from the factory and the need for adjustment should rarely occur. Uneven blade wear and crooked cuts may be the result of improper adjustment. Each bearing assembly has an eccentric bushing that allows the distance between the blade and bearings to be adjusted. The bearings are secured in place by a hex nut and a lock washer as shown in **Figure 39**.

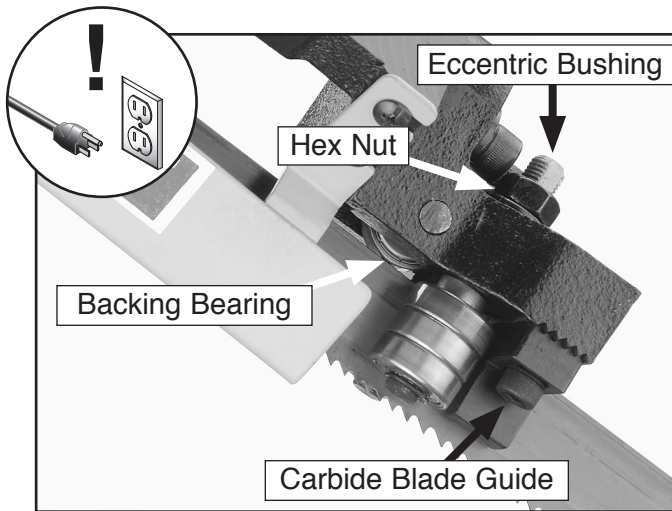


Figure 39. Blade guide adjustments.

To adjust the blade guide bearings:

1. UNPLUG THE BANDSAW!
2. Raise the bandsaw to the highest position and close the feed rate ON/OFF valve.
3. Loosen the hex nut that secures the eccentric bushing.
4. Adjust the eccentric bushing position to achieve the desired clearance. The bearing and blade should make light contact or have a clearance of 0.001"-0.002".
5. Tighten the nut to lock the eccentric bushing and bearing in position.
6. Adjust the other eccentric blade guide bearing in the same manner. The backing bearing is not adjustable and will make light contact with the blade.
7. Adjust the carbide blade guides so they make the same contact with the blade as the bearings.



Electrical Components



Figure 40. Circuit breaker.



Figure 43. Coolant pump ON/OFF Switch.

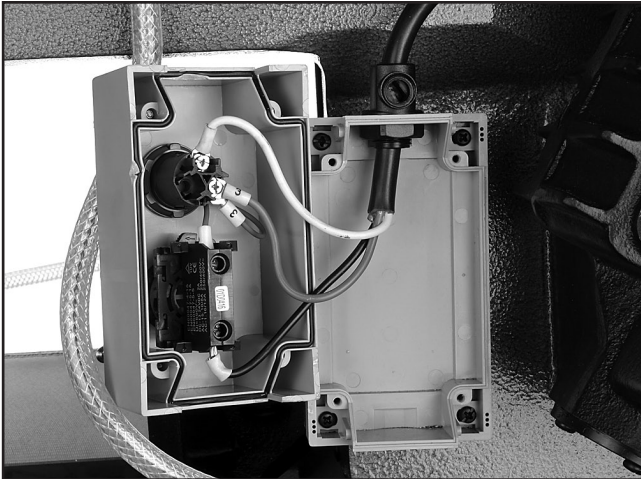


Figure 41. Bandsaw ON and E-Stop Switches.

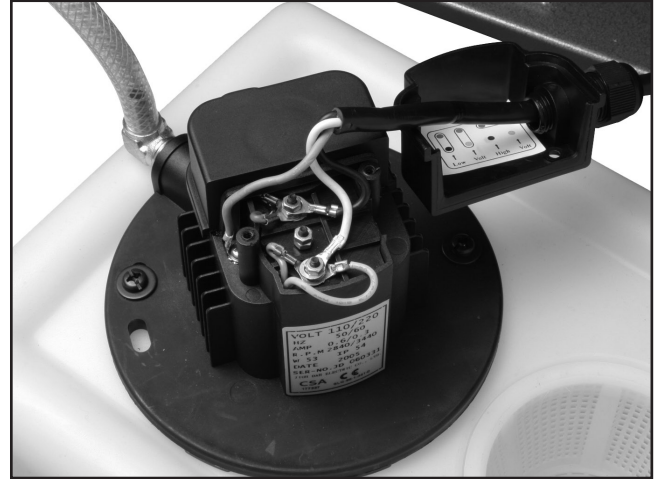


Figure 44. Pump junction box.

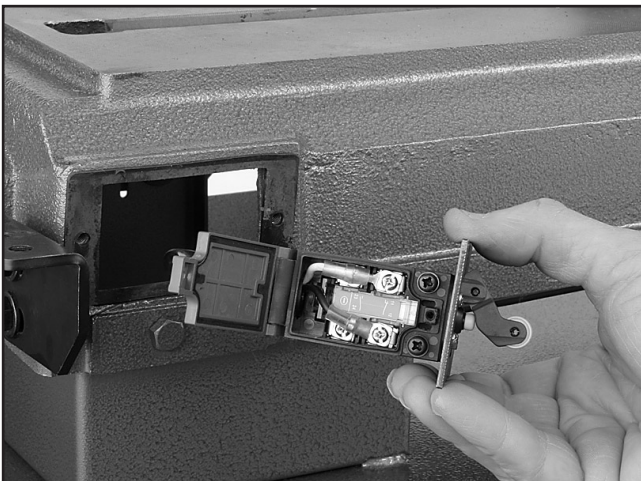


Figure 42. Auto-shutoff switch.



Electrical Components

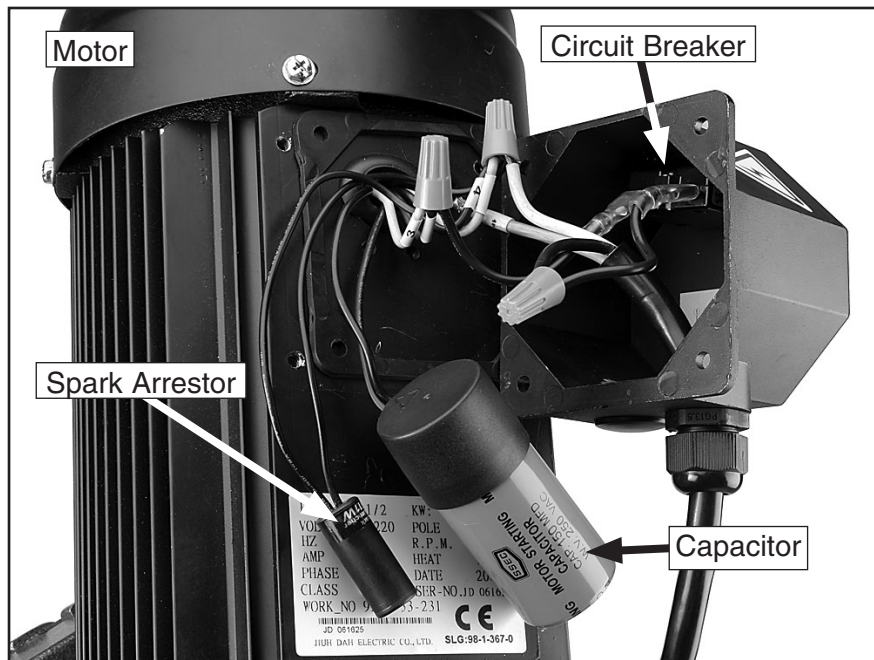


Figure 45. Motor wiring inside junction box.

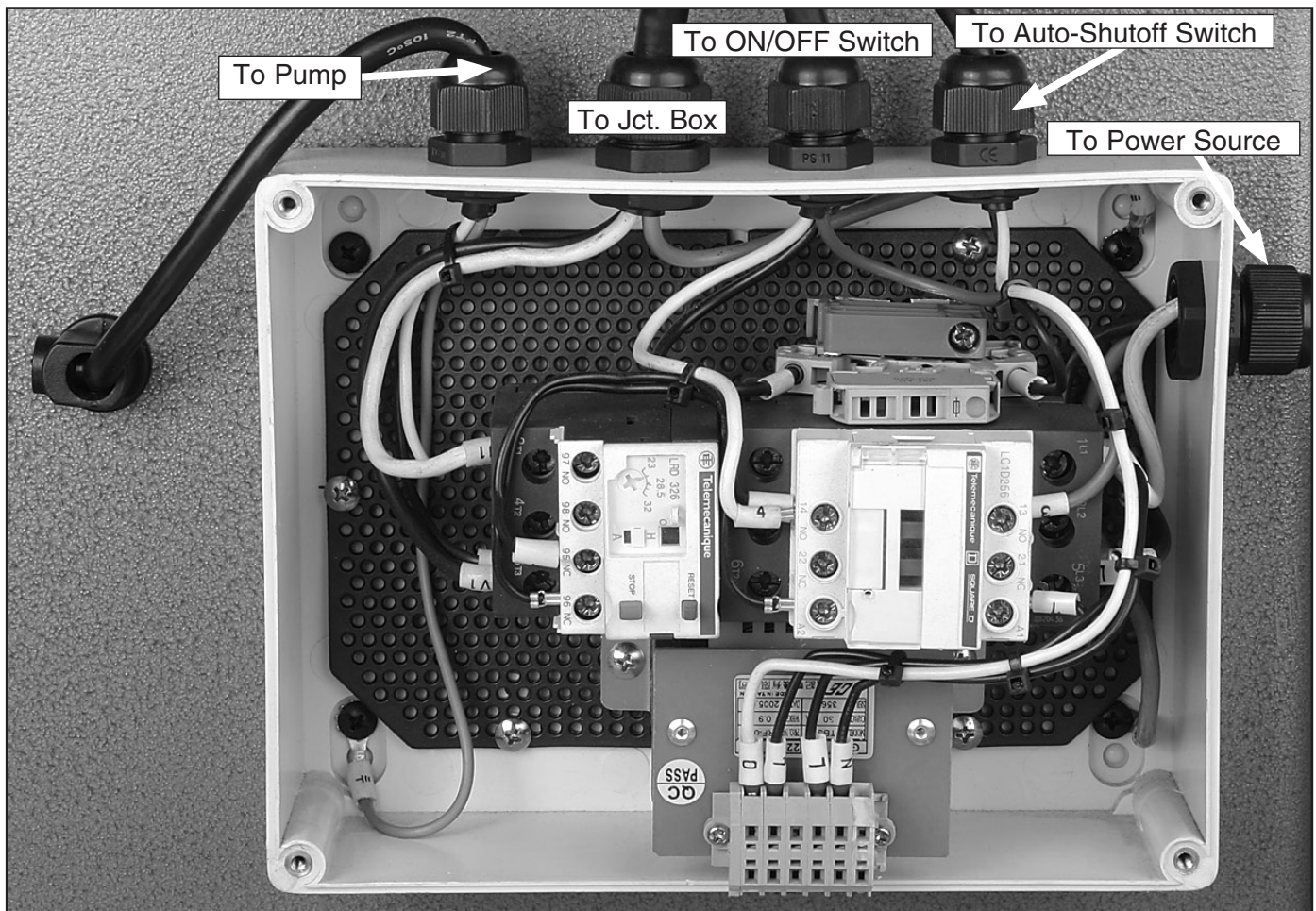


Figure 46. Contactor wiring.



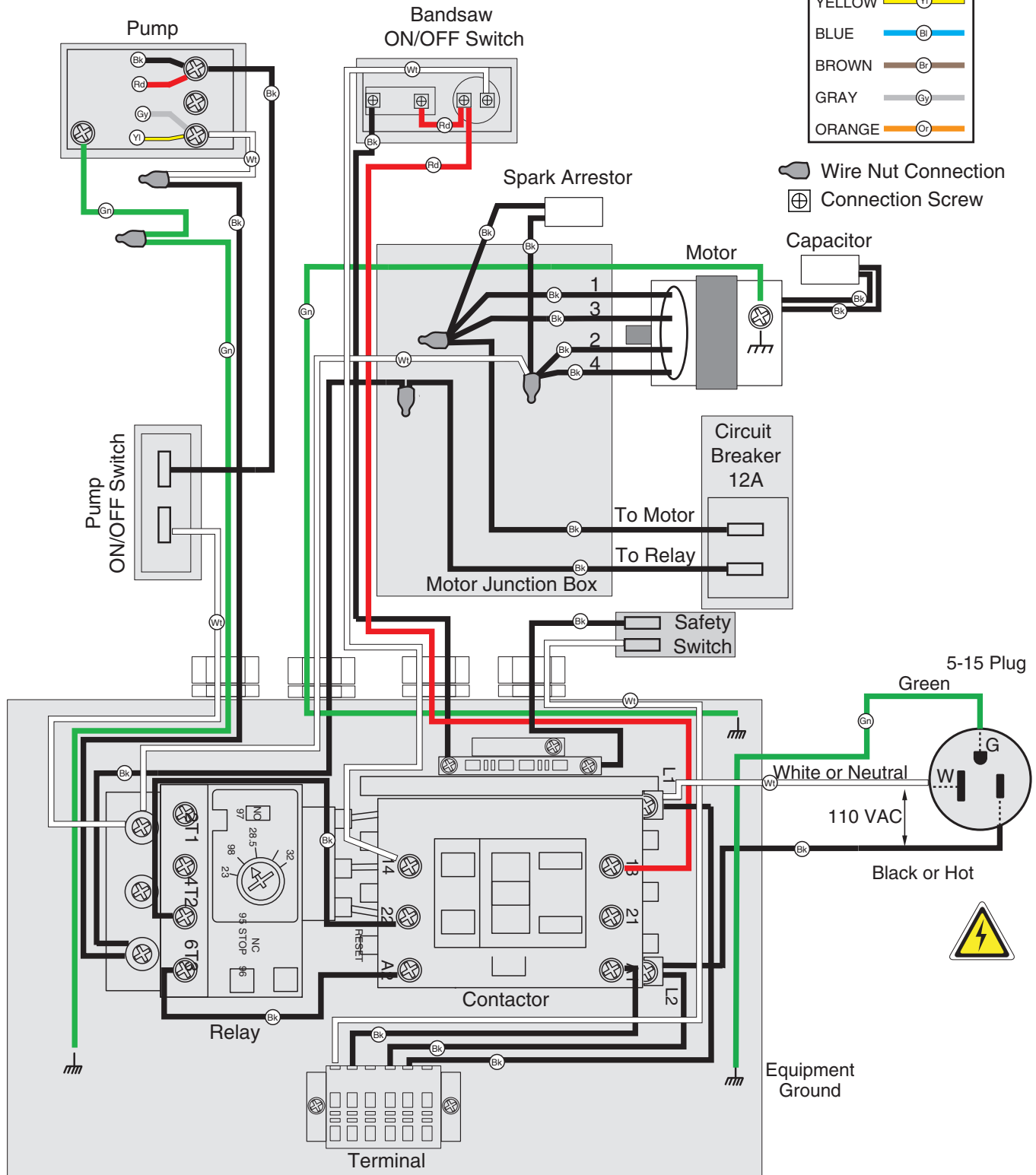
110V Wiring Diagram



⚠ DANGER
 Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal injury and even death!

COLOR KEY

BLACK	—(Bk)—
WHITE	—(Wh)—
GREEN	—(Gr)—
RED	—(Rd)—
YELLOW	—(Yl)—
BLUE	—(Bl)—
BROWN	—(Br)—
GRAY	—(Gy)—
ORANGE	—(Or)—



220V Wiring Diagram

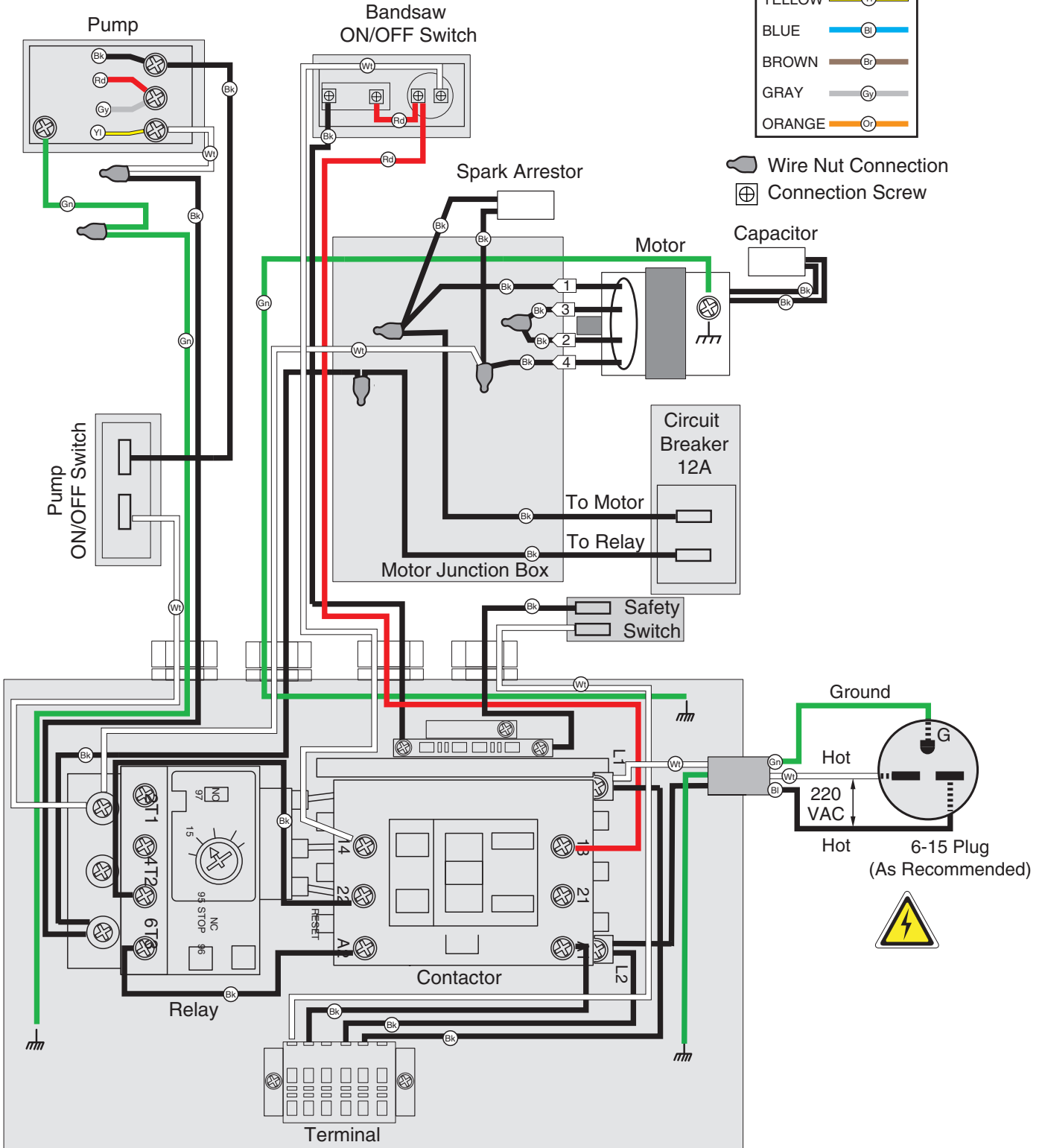


⚠ DANGER
 Disconnect power before performing any electrical service. Electricity presents serious shock hazards that will result in severe personal injury and even death!

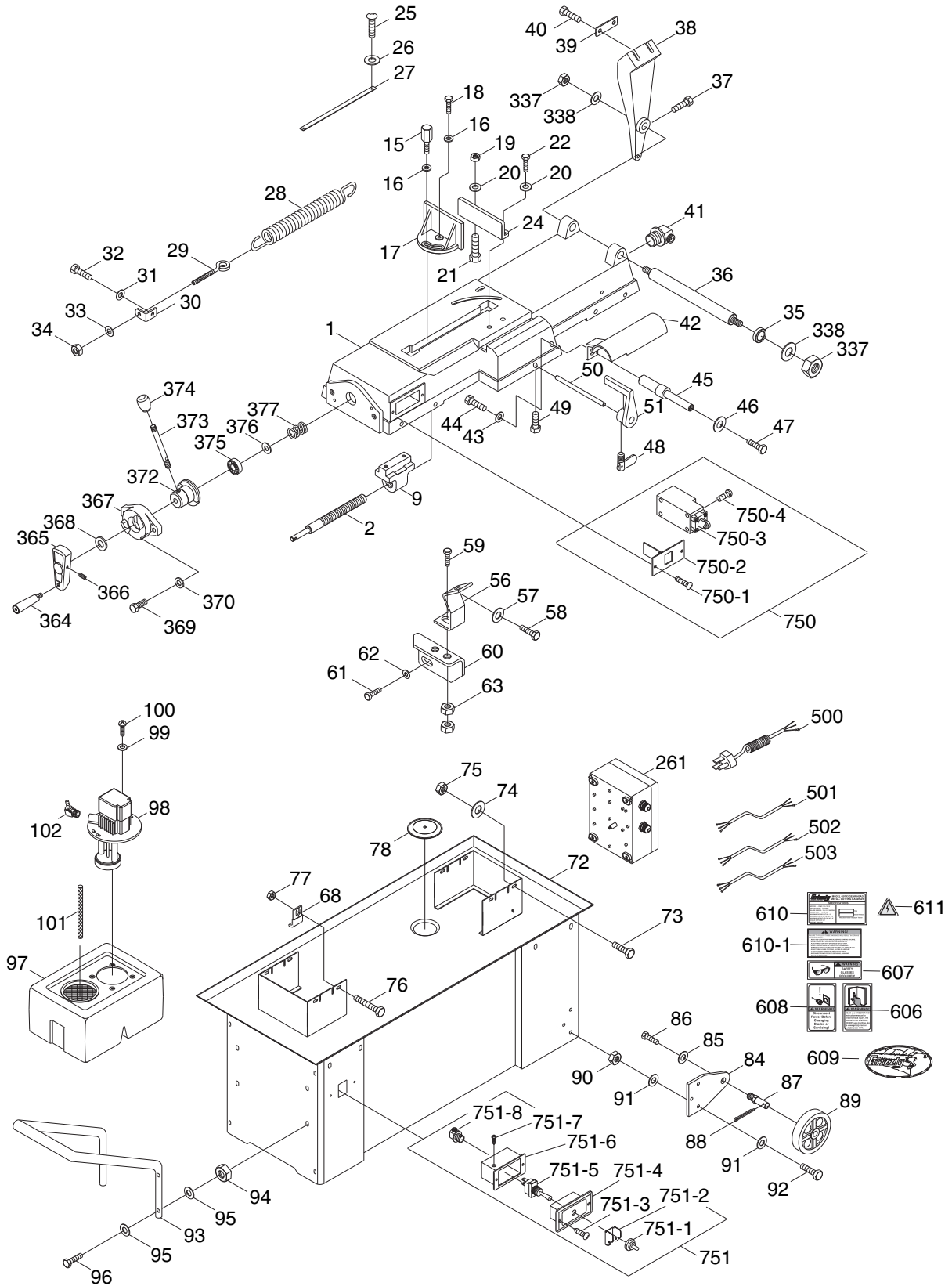
COLOR KEY

BLACK	
WHITE	
GREEN	
RED	
YELLOW	
BLUE	
BROWN	
GRAY	
ORANGE	

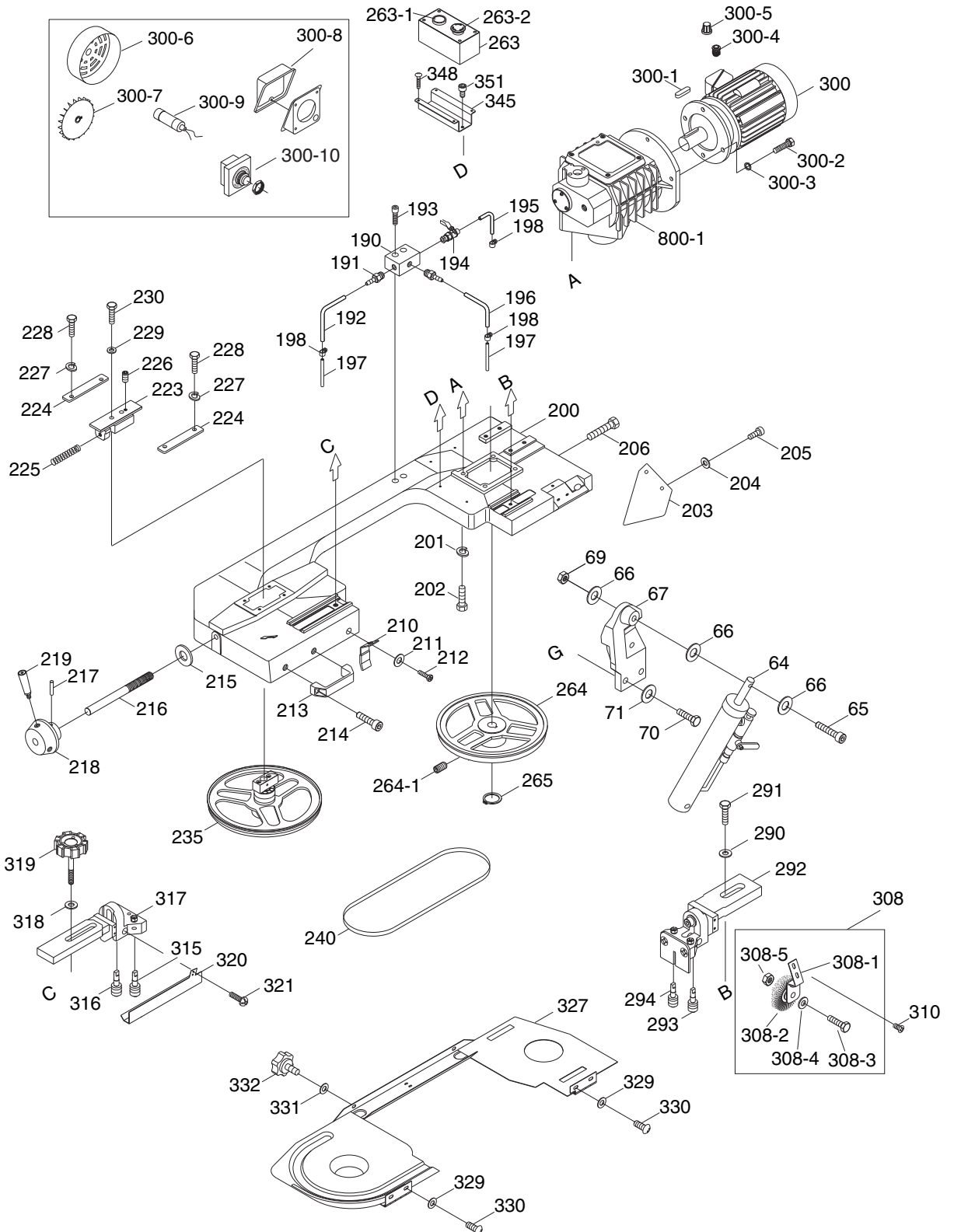
Wire Nut Connection
 Connection Screw



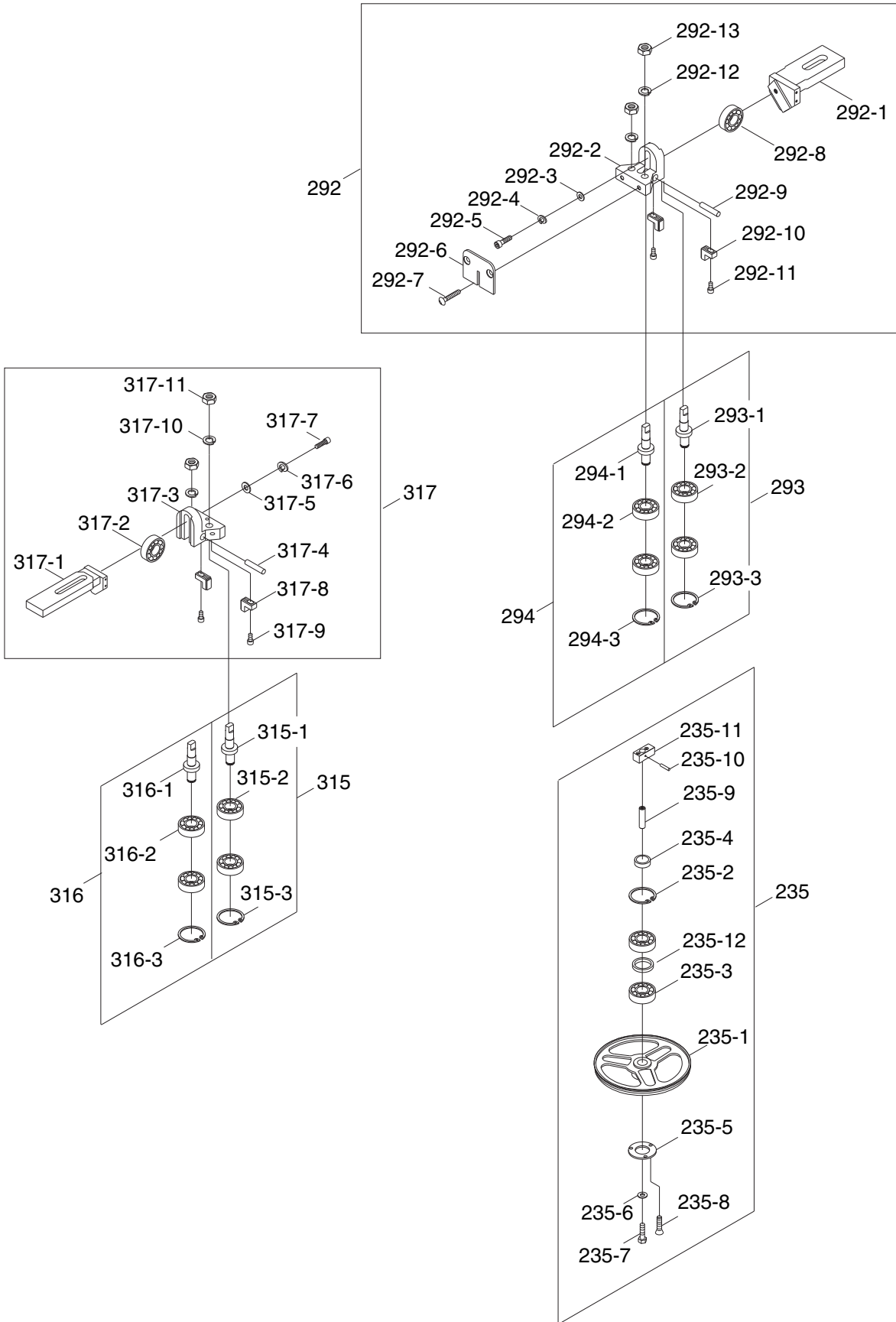
Base/Stand



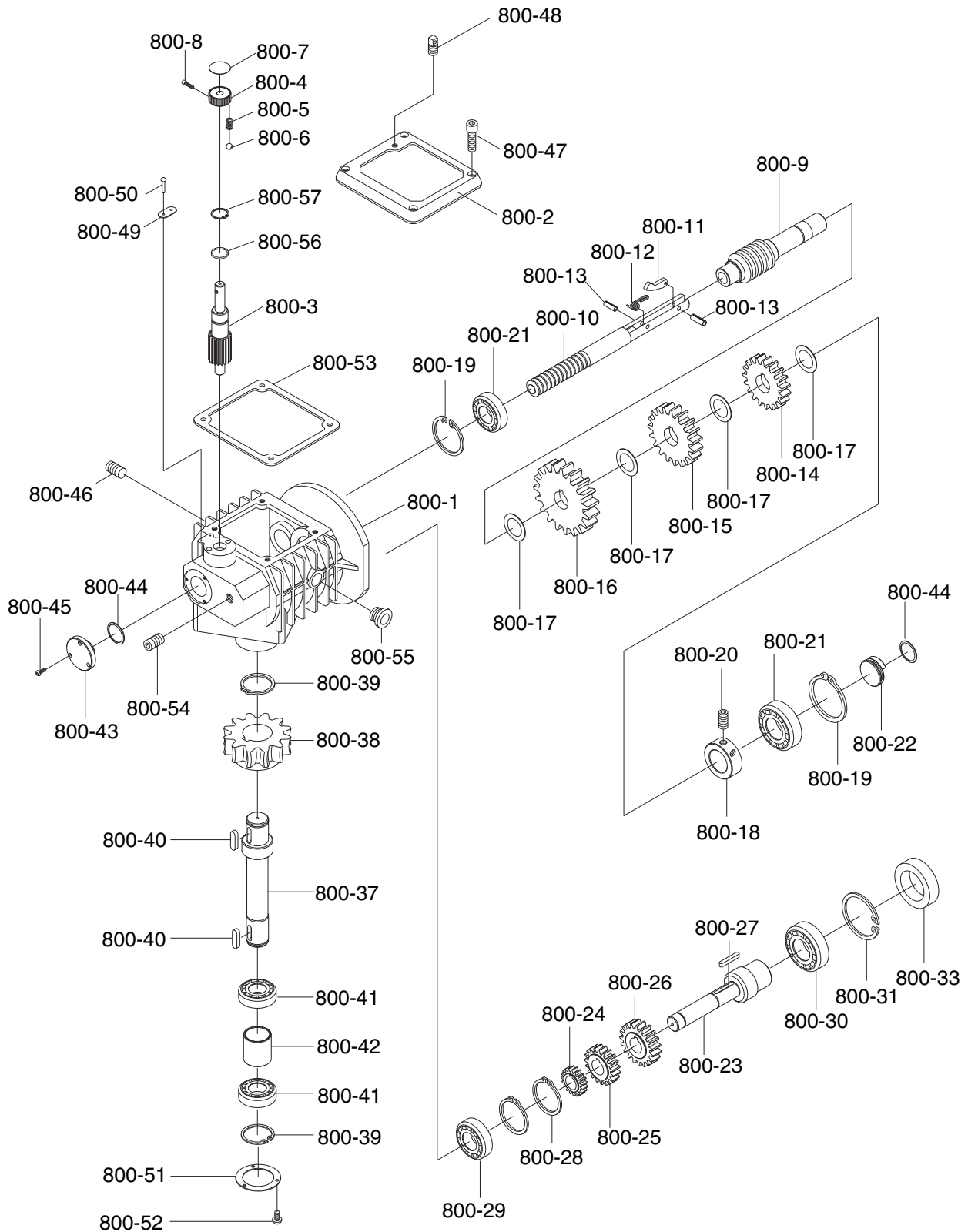
Head



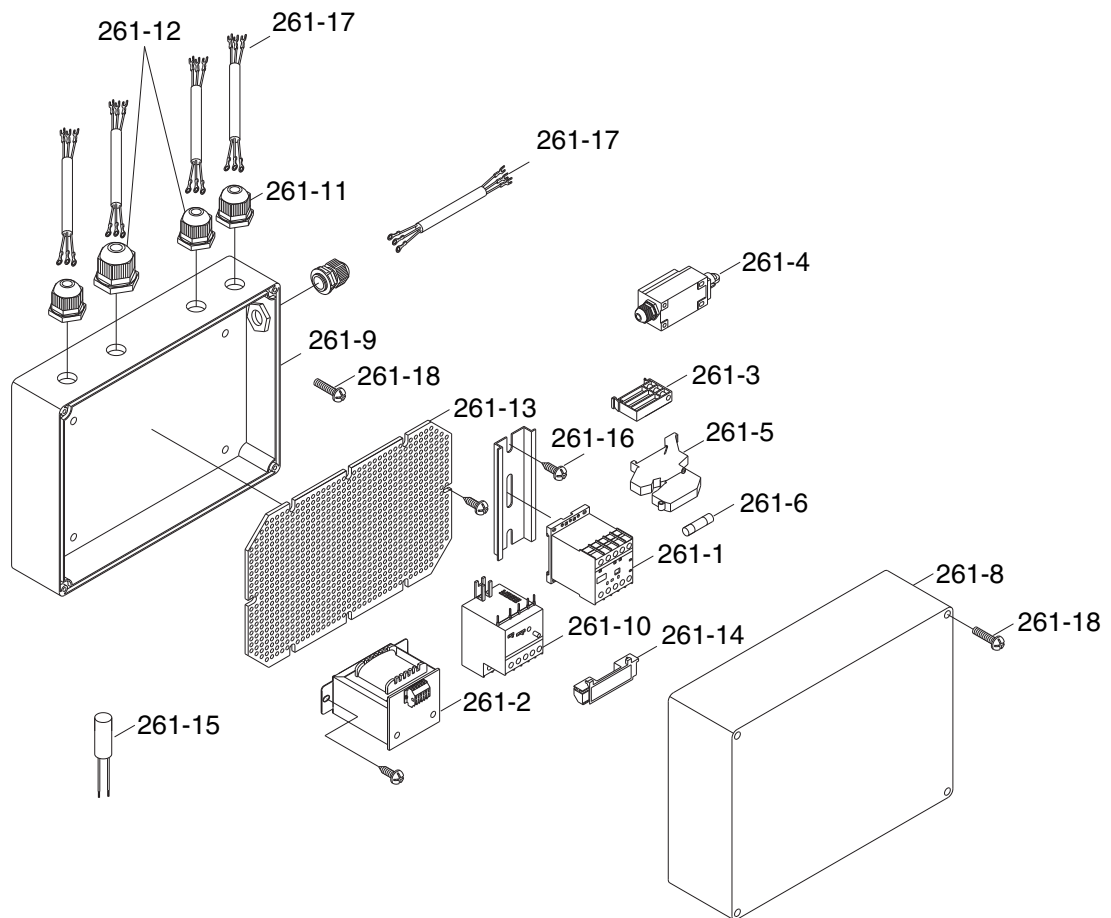
Misc. Assemblies



Gearbox



Electrical Box



Parts List

REF	PART #	DESCRIPTION
1	P9743001	BASE
2	P9743002	ACME SCREW
9	P9743009	ACME NUT
15	P9743015	FIXED BOLT
16	PW01M	FLAT WASHER 3/8
17	P9743017	WISE JAW BRACKET (FRONT)
18	PB16	HEX BOLT 3/8-16 X 1-1/2
19	PN06	HEX NUT 1/2-12
20	PW01	FLAT WASHER 1/2
21	PCB21	CARRIAGE BOLT 1/2-12 X 2 1/2
22	PB42	HEX BOLT 1/2-12 X 2
24	P9743024	WISE JAW BRACKET (REAR)
25	PS06	PHLP HD SCR 10-24 X 3/8
26	PW03	FLAT WASHER #10
27	P9743027	SCALE
28	P9743028	EXTENSION SPRING
29	P9743029	SPRING ADJUSTNG BOLT
30	P9743030	SPRING HANDLE BRACKET
31	PW07	FLAT WASHER 5/16
32	PB07	HEX BOLT 5/16-18 X 3/4
33	PW02	FLAT WASHER 3/8
34	PN08	HEX NUT 3/8-16
35	P9743035	BUSHING
36	P9743036	SUPPORT ROD
37	PB07	HEX BOLT 5/16-18 X 3/4
38	P9743038	PIVOT BRACKET
39	P9743039	BRACKET WASHER
40	PB16	HEX BOLT 3/8-16 X 1-1/2
41	P9743041	STRAIN RELIEF 5/8
42	P9743042	CYLINDER PROTECTOR
43	PW07	FLAT WASHER 5/16
44	PB07	HEX BOLT 5/16-18 X 3/4
45	P9743045	CYLINDER LOWER SUPPORT
46	PW07	FLAT WASHER 5/16
47	PB09	HEX BOLT 5/16-18 X 1/2
48	P9743048	THUMB SCREW
49	PB07	HEX BOLT 5/16-18 X 3/4
50	P9743050	STOCK STOP ROD
51	P9743051	STOP BLOCK
56	P9743056	SHIPPING BRACKET
57	PW07	FLAT WASHER 5/16
58	PB11	HEX BOLT 5/16-18 X 1-1/2
59	PB25	HEX BOLT 3/8-16 X 1-3/4
60	P9743060	SUPPORT PLATE
61	PB07	HEX BOLT 5/16-18 X 3/4
62	PLW01	LOCK WASHER 5/16
63	PN08	HEX NUT 3/8-16
64	P4030164	CYLINDER
65	PSB29	CAP SCREW 3/8-16 X 2-1/4
66	PLW04	LOCK WASHER 3/8

REF	PART #	DESCRIPTION
67	P9743067	CYLINDER UPPER SUPPORT
68	P9743068	SHUT-OFF SWITCH TAB
69	PN08	HEX NUT 3/8-16
70	PB03	HEX BOLT 5/16-18 X 1
71	PW07	FLAT WASHER 5/16
72	P9743072	STAND COMPLETE ASSEMBLY
73	PB03	HEX BOLT 5/16-18 X 1
74	PLW01	LOCK WASHER 5/16
75	PN02	HEX NUT 5/16-18
76	PB24	HEX BOLT 3/8-16 X 1-1/4
77	PN08	HEX NUT 3/8-16
78	P9743078	FILTER
84	P9743084	WHEEL BRACKET
85	PW02	FLAT WASHER 3/8
86	PB65	HEX BOLT 3/8-16 x 5/8
87	P9743087	AXLE
88	P9743088	COTTER PIN 3 X 25
89	P9743089	WHEEL
90	PN02	HEX NUT 5/16-18
91	PW07	FLAT WASHER 5/16
92	PB11	HEX BOLT 5/16-18 X 1-1/2
93	P9743093	HANDLE
94	PN02	HEX NUT 5/16-18
95	PW07	FLAT WASHER 5/16
96	PB11	HEX BOLT 5/16-18 X 1-1/2
97	P0561082	COOLANT TANK
98	P9743098	PUMP
99	PW06	FLAT WASHER 1/4
100	PS12	PHLP HD SCR 1/4-20 X 5/8
101	P9743101	HOSE 5/8 X 200MM
102	P1758088	HOSE FITTING
190	P9743190	3-WAY MANIFOLD
191	P9743191	HOSE FITTING
192	P9743192	HOSE 8 X 1100MM
193	PSB32	CAP SCREW 1/4-20 X 1-1/4
194	P9743194	VALVE
195	P9743195	HOSE 12 X 1400MM
196	P9743196	HOSE 8 X 400MM
197	P9743197	HOSE BIB
198	P9743198	HOSE CLAMP
200	P9743200	BODY FRAME
201	PLW04	LOCK WASHER 3/8
202	PB24	HEX BOLT 3/8-16 X 1-1/4
203	P9743203	SUPPORT PLATE
204	PW06	FLAT WASHER 1/4
205	PSB04	CAP SCREW 1/4-20 X 1/2
206	PB07	HEX BOLT 5/16-18 X 3/4
210	P9743210	SHUT-OFF SWITCH TAB
211	PW06	FLAT WASHER 1/4
212	PSB01	CAP SCREW 1/4-20 X 5/8



Parts List

REF	PART #	DESCRIPTION
213	P9743213	HANDLE
214	PSB03	CAP SCREW 5/16-18 X 1
215	PLW04	LOCK WASHER 3/8
216	P9743216	BLADE TENSION BAR
217	PRP42M	ROLL PIN 3 X 20
218	P9743218	HANDLE BODY
219	P9743219	HANDLE
223	P9743223	BLADE TENSION SLIDING BLOCK
224	P9743224	SLIDING PLATE
225	P9743225	COMPRESSION SPRING
226	PSS18	SET SCREW 5/16-18 X 3/4
227	PLW01	LOCK WASHER 5/16
228	PB03	HEX BOLT 5/16-18 X 1
229	PW07	FLAT WASHER 5/16
230	PB11	HEX BOLT 5/16-18 X 1-1/2
235	P9743235	IDLER WHEEL ASSY
235-1	P9743235-1	IDLER WHEEL
235-2	PR26M	INT RETAINING RING 52MM
235-3	P9743235-3	BEARING 6205
235-4	P9743235-4	BUSHING
235-5	P9743235-5	BEARING COVER
235-6	PW07	FLAT WASHER 5/16
235-7	PB07	HEX BOLT 5/16-18 X 3/4
235-8	PS06	PHLP HD SCR 10-24 X 3/8
235-9	P9743235-9	BLADE WHEEL SHAFT
235-10	PRP77M	ROLL PIN 5 X 34
235-11	P9743235-11	SLIDING PLATE DRAW BLOCK
235-12	P9743235-12	SPACER
240	H2317	BLADE 104-1/2 X 1
261	P9743261	ELECTRICAL BOX
261-1	P9743261-1	MAGNETIC CONTACTOR LC1D256
261-2	P9743261-2	TRANSFORMER
261-3	P9743261-3	TERMINAL BLOCK
261-4	P9743261-4	LIMIT SWITCH
261-5	P9743261-5	FUSE 281-611
261-6	P9743261-6	FUSE 2A
261-8	P9743261-8	ELECTRICAL BOX
261-9	P9743261-9	ELECTRICAL BOX
261-10	P9743261-10	THERMAL OVERLOAD LRD 326
261-11	P9743261-11	STRAIN RELIEF
261-12	P9743261-12	STRAIN RELIEF
261-13	P9743261-13	NET PIN
261-14	P9743261-14	CLIP
261-15	P9743261-15	ARRESTOR
261-16	PHTEK12M	TAP SCREW M5 X 15
261-17	P9743261-17	POWER CABLE
261-18	PS04	PHLP HD SCR 1/4-20 X 1/2
263	P9473263	CONTROL BOX
263-1	P9473263-1	PUSH BUTTON SWITCH
263-2	P9473263-2	EMERGENCY STOP SWITCH

REF	PART #	DESCRIPTION
264	P9743264	DRIVE BLADE WHEEL
264-1	PSS03	SET SCREW 1/4-20 X 3/8
265	PR11M	EXT RETAINING RING 25MM
290	PW02	FLAT WASHER 3/8
291	PB24	HEX BOLT 3/8-16 X 1-1/4
292	P9743292	ADJUSTABLE BRACKET ASSY
292-1	P9743292-1	ADJUSTABLE BRACKET
292-2	P9743292-2	BLADE ADJUSTER
292-3	PW07	FLAT WASHER 5/16
292-4	PLW01	LOCK WASHER 5/16
292-5	PSB11	CAP SCREW 5/16-18 X 1-1/4
292-6	P9743292-6	DEFLECTOR PLATE
292-7	PS04	PHLP HD SCR 1/4-20 X 1/2
292-8	P608	BEARING 608
292-9	P9743292-9	BEARING PIN
292-10	P9743292-10	CARBIDE GUIDE
292-11	PSB01M	CAP SCREW M6-1 X 16
292-12	PLW04	LOCK WASHER 3/8
292-13	PN11	HEX NUT 3/8-24
293	P9743293	GUIDE PIVOT (RIGHT)ASSY
293-1	P9743293-1	GUIDE PIVOT (RIGHT)
293-2	P608	BEARING 608
293-3	PR40M	INT RETAINING RING 26MM
294	P9743294	GUIDE PIVOT (LEFT)ASSY
294-1	P9743294-1	GUIDE PIVOT (LEFT)
294-2	P608	BEARING 608
294-3	PR40M	INT RETAINING RING 26MM
300	P9743300	MOTOR 1-1/2HP 110V 60HZ 1PH
300-1	PK12M	KEY 5 X 5 X 30
300-2	PB32M	HEX BOLT M10-1.5 X 25
300-3	PLW06M	LOCK WASHER 10MM
300-4	P9743300-4	STRAIN RELIEF
300-5	P9743300-5	WIRE NUT
300-6	P9743300-6	FAN COVER
300-7	P9743300-7	FAN
300-8	P9743300-8	JUNCTION BOX
300-9	PC150A	CAPACITOR 150MFD 250 VAC
300-10	P9743300-10	CIRCUIT BREAKER
308	P9743308	BRUSH ASSY
308-1	P9743308-1	BRUSH SUPPORT
308-2	P9743308-2	BRUSH
308-3	PB29M	HEX BOLT M6-1 X 30
308-4	PW03M	FLAT WASHER 6MM
308-5	PN01M	HEX NUT M6-1
310	PS06	PHLP HD SCR 10-24 X 3/8
315	P9743315	GUIDE PIVOT (RIGHT)ASSY
315-1	P9743315-1	GUIDE PIVOT (RIGHT)
315-2	P608	BEARING 608
315-3	PR40M	INT RETAINING RING 26MM
316	P9743316	GUIDE PIVOT (LEFT)ASSY



Parts List

REF	PART #	DESCRIPTION
316-1	P9743316-1	GUIDE PIVOT (LEFT)
316-2	P608	BEARING 608
316-3	PR40M	INT RETAINING RING 26MM
317	P9743317	ADJ BRACKET (FRONT) ASSY
317-1	P9743317-1	ADJUSTABLE BRACKET (FRONT)
317-2	P608	BEARING 608
317-3	P9743317-3	BLADE ADJUSTER (REAR)
317-4	P9743317-4	BEARING PIN
317-5	PW07	FLAT WASHER 5/16
317-6	PLW01	LOCK WASHER 5/16
317-7	PSB11	CAP SCREW 5/16-18 X 1-1/4
317-8	P9743317-8	CARBIDE GUIDE
317-9	PB83M	HEX BOLT M6-1 X 16
317-10	PLW04	LOCK WASHER 3/8
317-11	PN11	HEX NUT 3/8-24
318	PLW04	LOCK WASHER 3/8
319	P9743319	BLADE ADJUSTER KNOB
320	P9743320	BLADE COVER (FRONT)
321	PS23	PHLP HD SCR 8-32 x 1/4
327	P9743327	BLADE BACK COVER
329	PW06	FLAT WASHER 1/4
330	PS04	PHLP HD SCR 1/4-20 X 1/2
331	PW06	FLAT WASHER 1/4
332	P9743332	COVER KNOB 1/4-20 X 1/2
337	PN06	HEX NUT 1/2-12
338	PW01	FLAT WASHER 1/2
345	P9743340	BRACKET
348	PS17M	PHLP HD SCR M6-1 X 12
351	PSB02	CAP SCREW 10-24 X 3/8
364	P9743364	CRANK HANDLE
365	P9743365	CAST IRON CRANK
366	PSS07	SET SCREW 1/4-20 X 1/2
367	P9743367	PRESSURE CLAMP
368	PW06M	FLAT WASHER 12MM
369	PB24	HEX BOLT 3/8-16 X 1-1/4
370	PLW04	LOCK WASHER 3/8
372	P9743372	PRESSURE SHAFT
373	P9743373	SHAFT
374	P9743374	SHAFT KNOB
375	P9743375	ACME SCREW BEARING
376	PW06M	FLAT WASHER 12MM
377	P9743377	COMPRESSION SPRING
500	P9743500	POWER CORD
501	P9743501	PUMP CORD
502	P9743502	LIMIT SWITCH CORD
503	P9743503	MOTOR CORD
606	P9743606	READ MANUAL LABEL
607	P9743607	SAFETY GLASSES LABEL
608	P9743608	UNPLUG LABEL
609	G8588	GRIZZLY LOGO PLATE

REF	PART #	DESCRIPTION
610	P9743610	MACHINE ID LABEL
610-1	P9743610-1	MACHINE WARNINGS LABEL
611	P9743611	ELECTRICITY LABEL
750	P9743750	SAFETY SWITCH ASSY
750-1	PS06	PHLP HD SCR 10-24 X 3/8
750-2	P9743750-2	SWITCH BRACKET
750-3	P9743750-3	SAFETY SWITCH
750-4	PS06	PHLP HD SCR 10-24 X 3/8
751	P9743751	PUMP TOGGLE SWITCH ASSY
751-1	P9743751-1	TOGGLE SWITCH COVER
751-2	P9743751-2	SWITCH COVER
751-3	PS06	PHLP HD SCR 10-24 X 3/8
751-4	P9743751-4	COVER
751-5	P9743751-5	TOGGLE SWITCH
751-6	P9743751-6	ELECTRICAL BOX
751-7	PS17M	PHLP HD SCR M4-.7 X 6
751-8	P9743751-8	STRAIN RELIEF
800-1	P9743800-1	GEAR BOX
800-2	P9743800-2	GEAR BOX COVER
800-3	P9743800-3	SPEED CHANGE GEAR SHAFT
800-4	P9743800-4	GEAR
800-5	P9743800-5	COMPRESSION SPRING
800-6	P9743800-6	STEEL BALL
800-7	P9743800-7	SPEED INDICATOR DIAL
800-8	PSB94M	CAP SCREW M5-.8 X 27
800-9	P9743800-9	WORM SHAFT
800-10	P9743800-10	SPEED CHANGE ROD
800-11	P9743800-11	SPEED CHANGE KEY
800-12	P9743800-12	TORSION SPRING
800-13	PRP44M	ROLL PIN 3 X 10
800-14	P9743800-14	GEAR
800-15	P9743800-15	GEAR
800-16	P9743800-16	GEAR
800-17	P9743800-17	GEAR SPACER
800-18	P9743800-18	BUSHING BRACKET
800-19	PR12M	EXT RETAINING RING 35MM
800-20	PSS02M	SET SCREW M6-1 X 6
800-21	P6003	BEARING 6003
800-22	P9743800-22	COVER
800-23	P9743800-23	GEAR SHAFT
800-24	P9743800-24	GEAR
800-25	P9743800-25	GEAR
800-26	P9743800-26	GEAR
800-27	PK15M	KEY 5 X 5 X 32
800-28	PR18M	EXT RETAINING RING 17MM
800-29	P6003	BEARING 6003
800-30	P6007	BEARING 6007
800-31	PR38M	INT RETAINING RING 62MM
800-33	P9743800-33	OIL SEAL
800-37	P9743800-37	DRIVE GEAR SHAFT



Parts List

REF	PART #	DESCRIPTION
800-38	P9743800-38	WORM GEAR
800-39	PR11M	EXT RETAINING RING 25MM
800-40	PK07M	KEY 6 X 6 X 20
800-41	P9743800-41	BEARING 60205
800-42	P9743800-42	BEARING SPACER
800-43	P9743800-43	COVER
800-44	P9743800-44	O-RING
800-45	PSBS06M	BUTTON HD CAP SCR M5-.8 X 12
800-46	P9743800-46	PLUG
800-47	PSB02M	CAP SCREW M6-1 X 20

REF	PART #	DESCRIPTION
800-48	P9743800-48	VENT PLUG
800-49	P9743800-49	SCALE
800-50	P9743800-50	RIVET
800-51	P9743800-51	BEARING COVER
800-52	PS09M	PHLP HD SCR M5-.8 X 10
800-53	P9743800-53	GASKET
800-54	P9743800-54	PLUG
800-55	P9743800-55	SIGHT GLASS
800-56	P9743800-56	O-RING
800-57	PR66M	INT RETAINING RING 25MM

WARNING

The safety labels on this machine warn and indicate how to protect the operator or bystander from machine hazards. The machine owner **MUST** maintain the original label location and readability. If a label is removed or becomes unreadable, **REPLACE** the label before using the machine. For new labels, contact Grizzly Industrial Inc. at (570) 546-9663 or techsupport@grizzly.com.



WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.







WARRANTY CARD

Name _____
 Street _____
 City _____ State _____ Zip _____
 Phone # _____ Email _____ Invoice # _____
 Model # _____ Order # _____ Serial # _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. **Of course, all information is strictly confidential.**

1. How did you learn about us?

Advertisement Friend Catalog
 Card Deck Website Other:

2. Which of the following magazines do you subscribe to?

<input type="checkbox"/> Cabinet Maker	<input type="checkbox"/> Popular Mechanics	<input type="checkbox"/> Today's Homeowner
<input type="checkbox"/> Family Handyman	<input type="checkbox"/> Popular Science	<input type="checkbox"/> Wood
<input type="checkbox"/> Hand Loader	<input type="checkbox"/> Popular Woodworking	<input type="checkbox"/> Wooden Boat
<input type="checkbox"/> Handy	<input type="checkbox"/> Practical Homeowner	<input type="checkbox"/> Woodshop News
<input type="checkbox"/> Home Shop Machinist	<input type="checkbox"/> Precision Shooter	<input type="checkbox"/> Woodsmith
<input type="checkbox"/> Journal of Light Cont.	<input type="checkbox"/> Projects in Metal	<input type="checkbox"/> Woodwork
<input type="checkbox"/> Live Steam	<input type="checkbox"/> RC Modeler	<input type="checkbox"/> Woodworker West
<input type="checkbox"/> Model Airplane News	<input type="checkbox"/> Rifle	<input type="checkbox"/> Woodworker's Journal
<input type="checkbox"/> Modeltec	<input type="checkbox"/> Shop Notes	<input type="checkbox"/> Other:
<input type="checkbox"/> Old House Journal	<input type="checkbox"/> Shotgun News	

3. What is your annual household income?

\$20,000-\$29,000 \$30,000-\$39,000 \$40,000-\$49,000
 \$50,000-\$59,000 \$60,000-\$69,000 \$70,000+

4. What is your age group?

20-29 30-39 40-49
 50-59 60-69 70+

5. How long have you been a woodworker/metalworker?

0-2 Years 2-8 Years 8-20 Years 20+ Years

6. How many of your machines or tools are Grizzly?

0-2 3-5 6-9 10+

7. Do you think your machine represents a good value?

Yes No

8. Would you recommend Grizzly Industrial to a friend?

Yes No

9. Would you allow us to use your name as a reference for Grizzly customers in your area?

Note: *We never use names more than 3 times.* Yes No

10. Comments: _____

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Place
Stamp
Here



GRIZZLY INDUSTRIAL, INC.
P.O. BOX 2069
BELLINGHAM, WA 98227-2069



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City _____ State _____ Zip _____

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